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(54) **STRAP FOR A WEARABLE DEVICE**

(52) **U.S. Cl.**

(71) Applicant: **Masimo Corporation**, Irvine, CA (US)

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(2013.01)

(72) Inventors: **Ammar Al-Ali**, San Juan Capistrano,
CA (US); **Chad A. DeJong**, Los
Angeles, CA (US); **Stephen Scruggs**,
Newport Beach, CA (US)

(57) **ABSTRACT**

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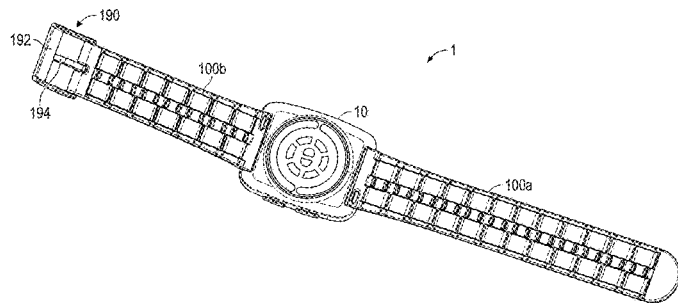
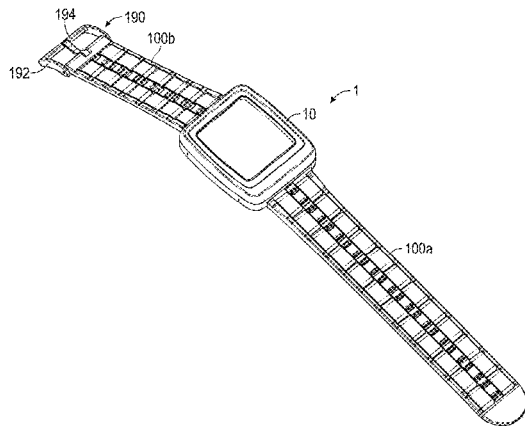
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20, 2020, provisional application No. 63/067,622,
filed on Aug. 19, 2020.

Publication Classification

(51) **Int. Cl.**
A44C 5/10 (2006.01)
A44C 5/00 (2006.01)

A strap for a wearable device configured to secure to a portion of a body of a user can include a base and a plurality of strap members secured to portions of the base. In some implementations, the base is made of a first material and each of the plurality of strap members are made of a second material, the first material being more pliable than the second material. In some implementations, the base includes a plurality of openings spaced from one another along a length of the base and a plurality of stems. In some implementations, each of the plurality of strap members is a channel secured to one of the stems. In some implementations, the first material includes at least one of rubber and silicone and the second material is a metallic material.



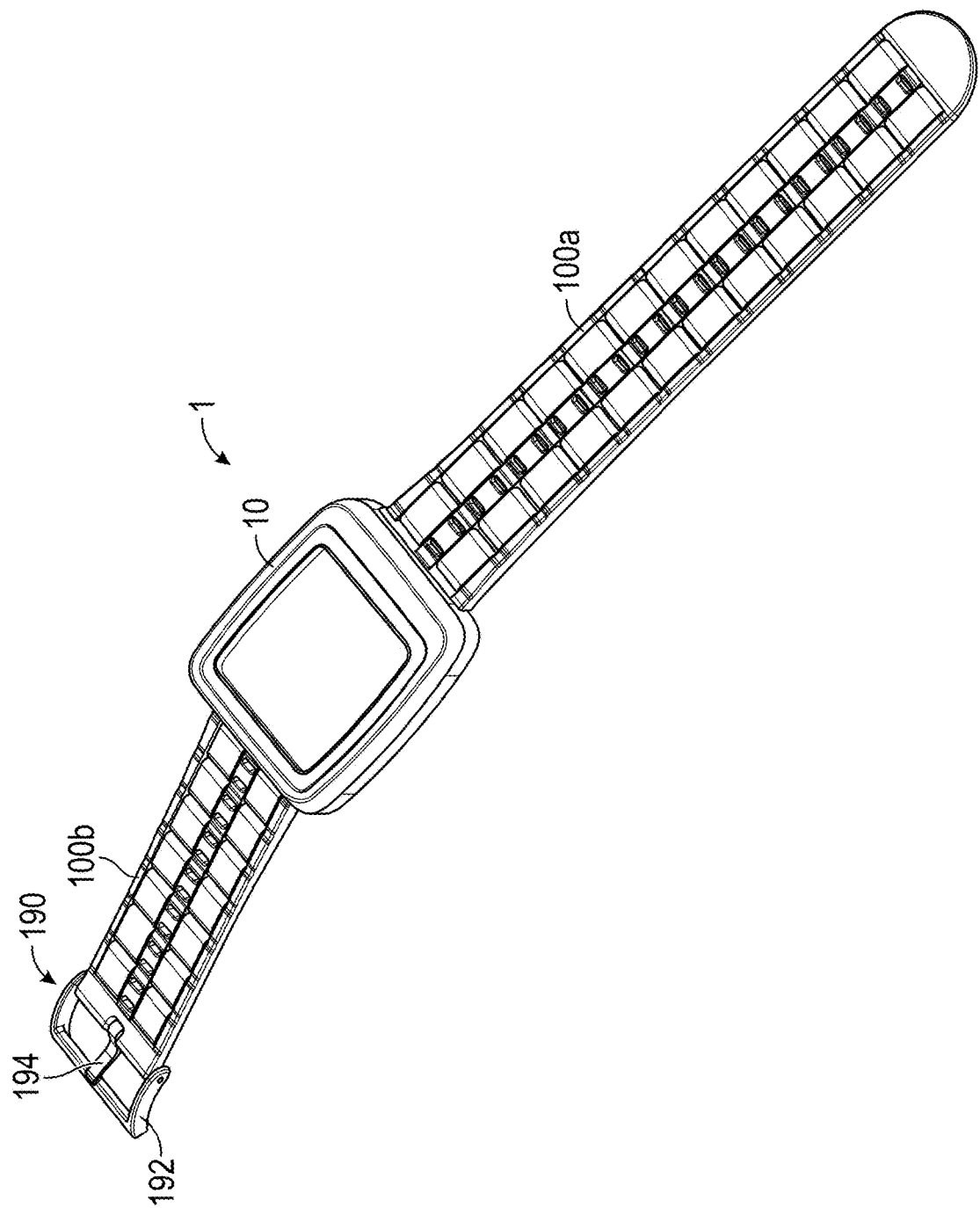


FIG. 1A

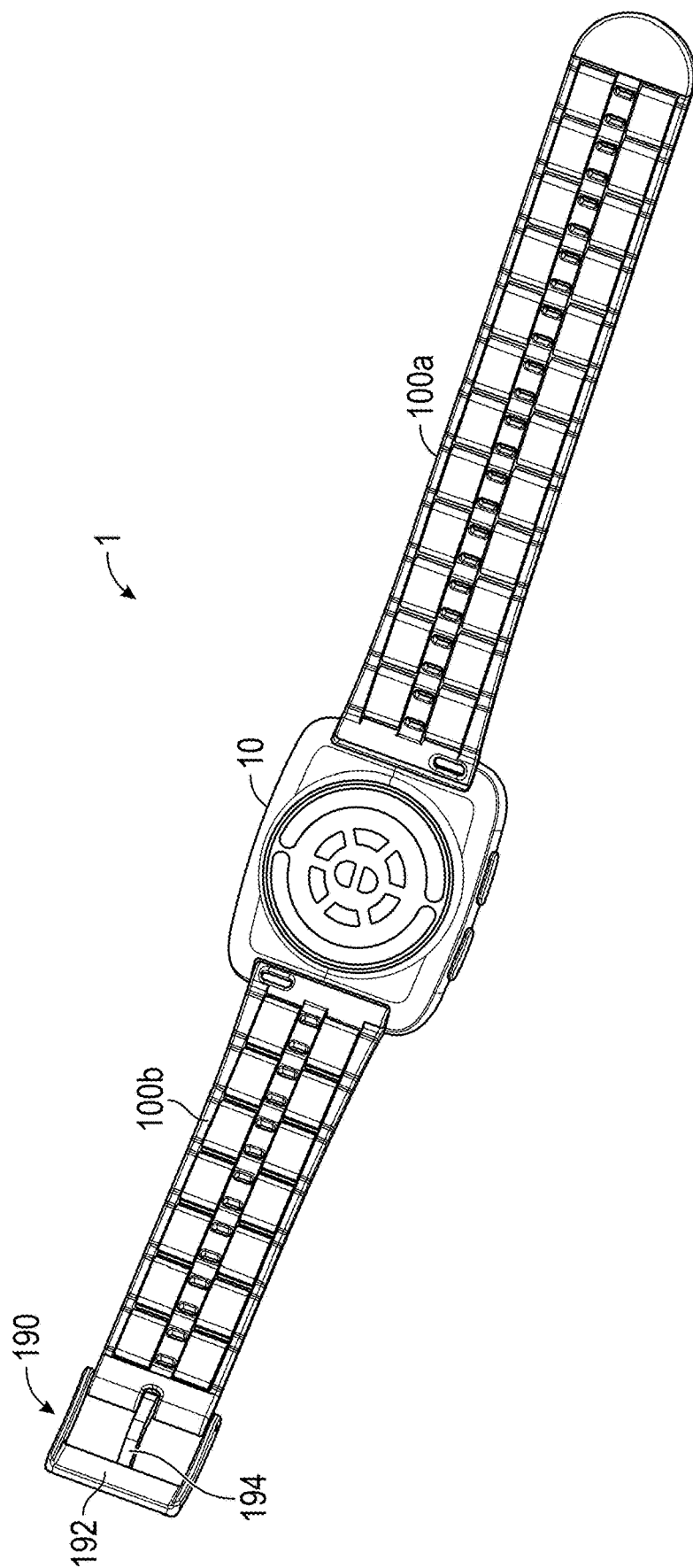


FIG. 1B

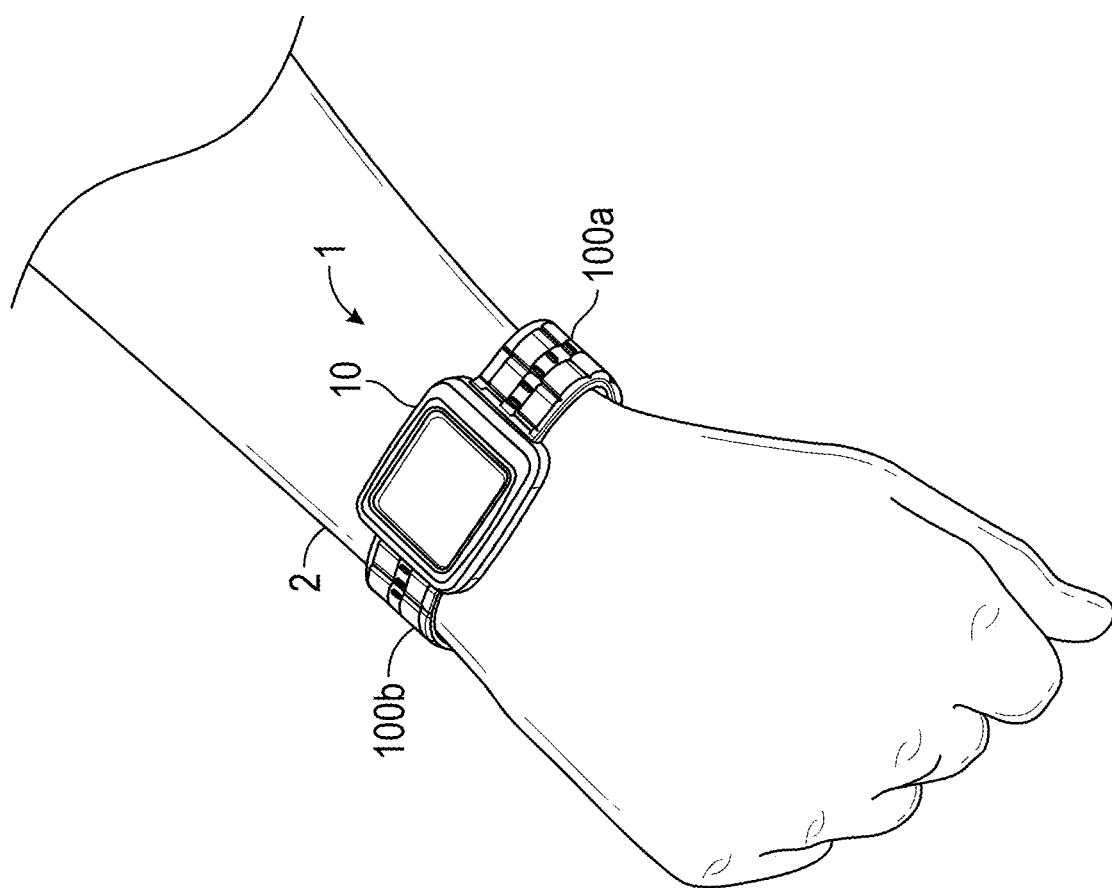


FIG. 1C

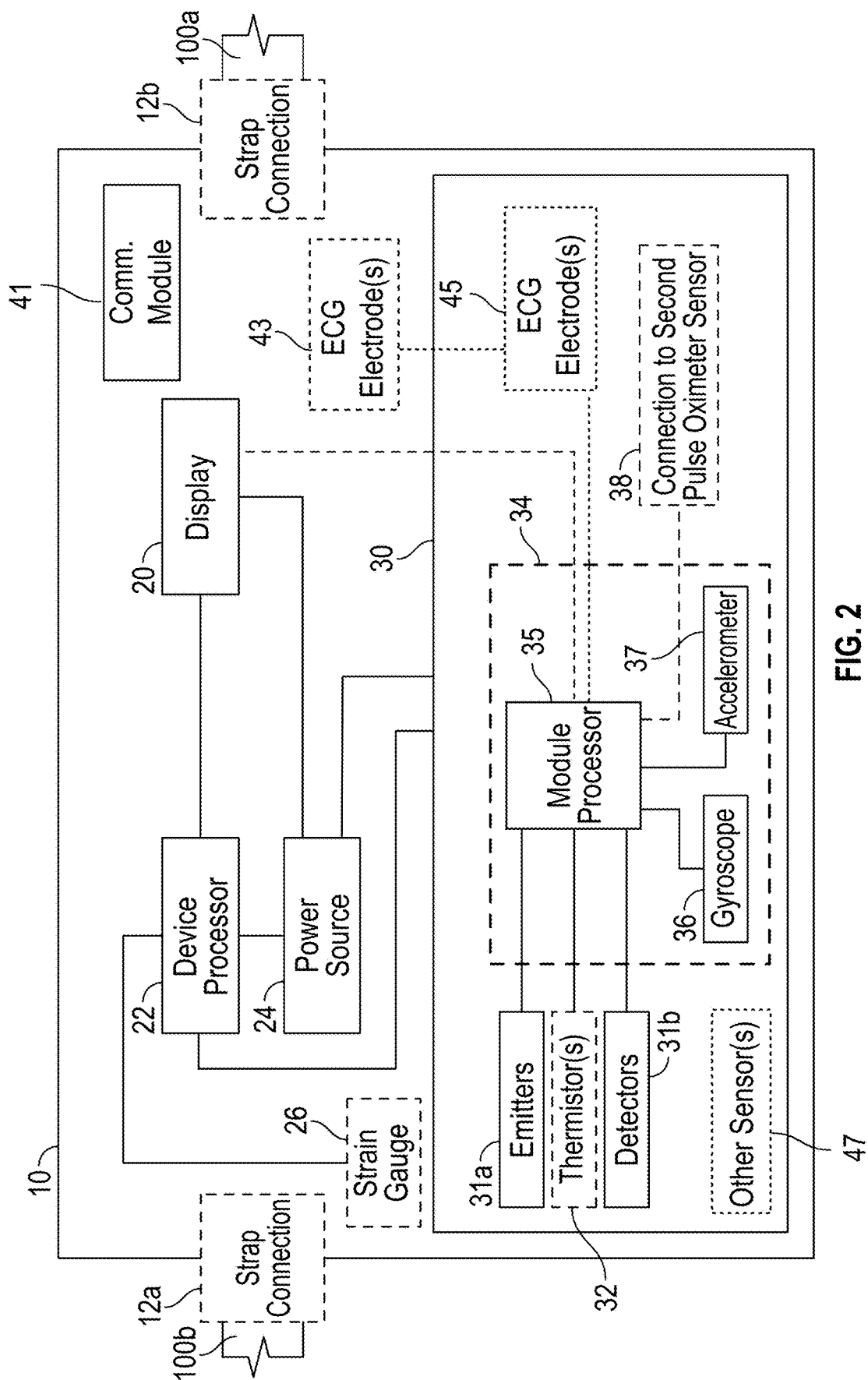


FIG. 2

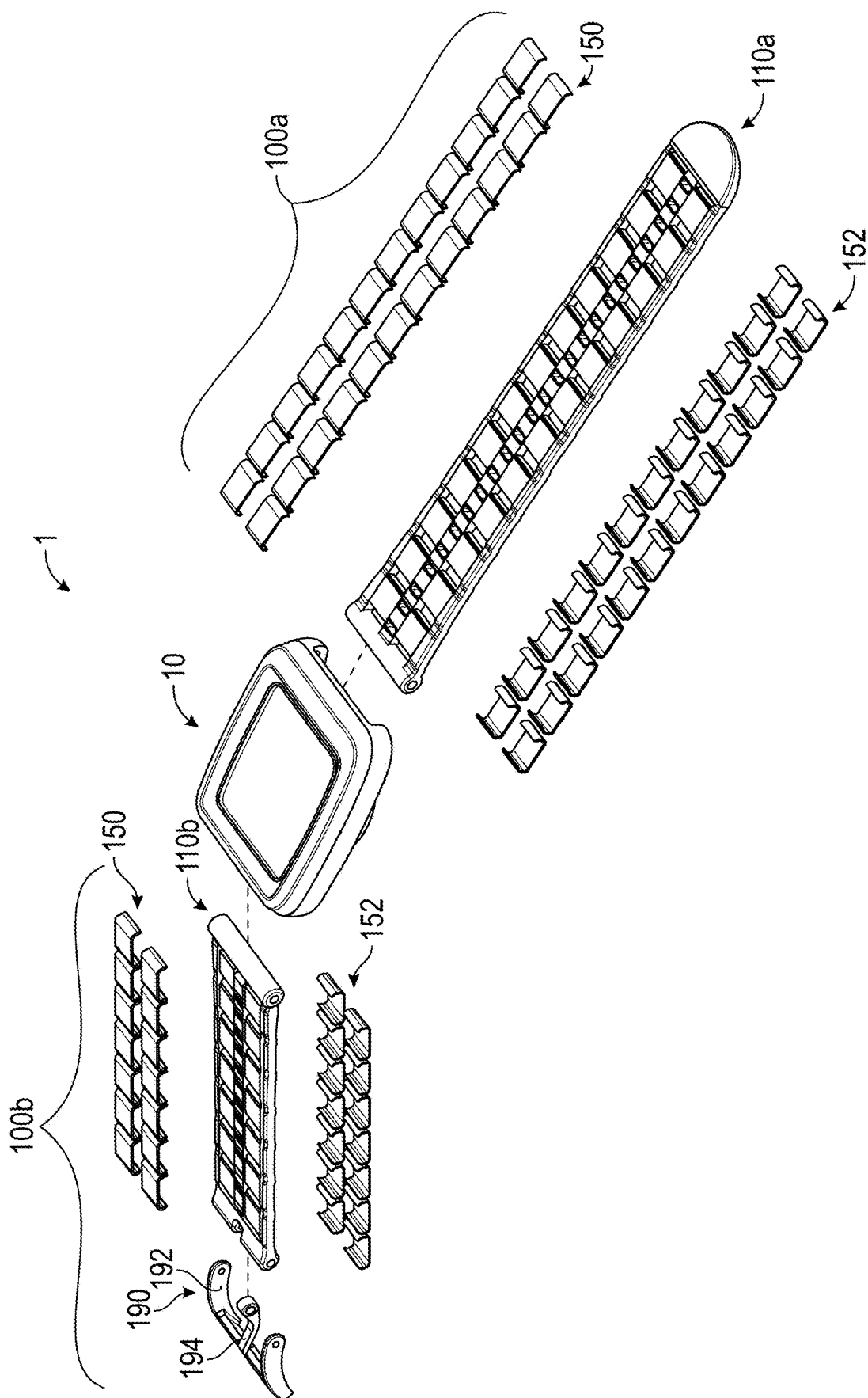


FIG. 3A

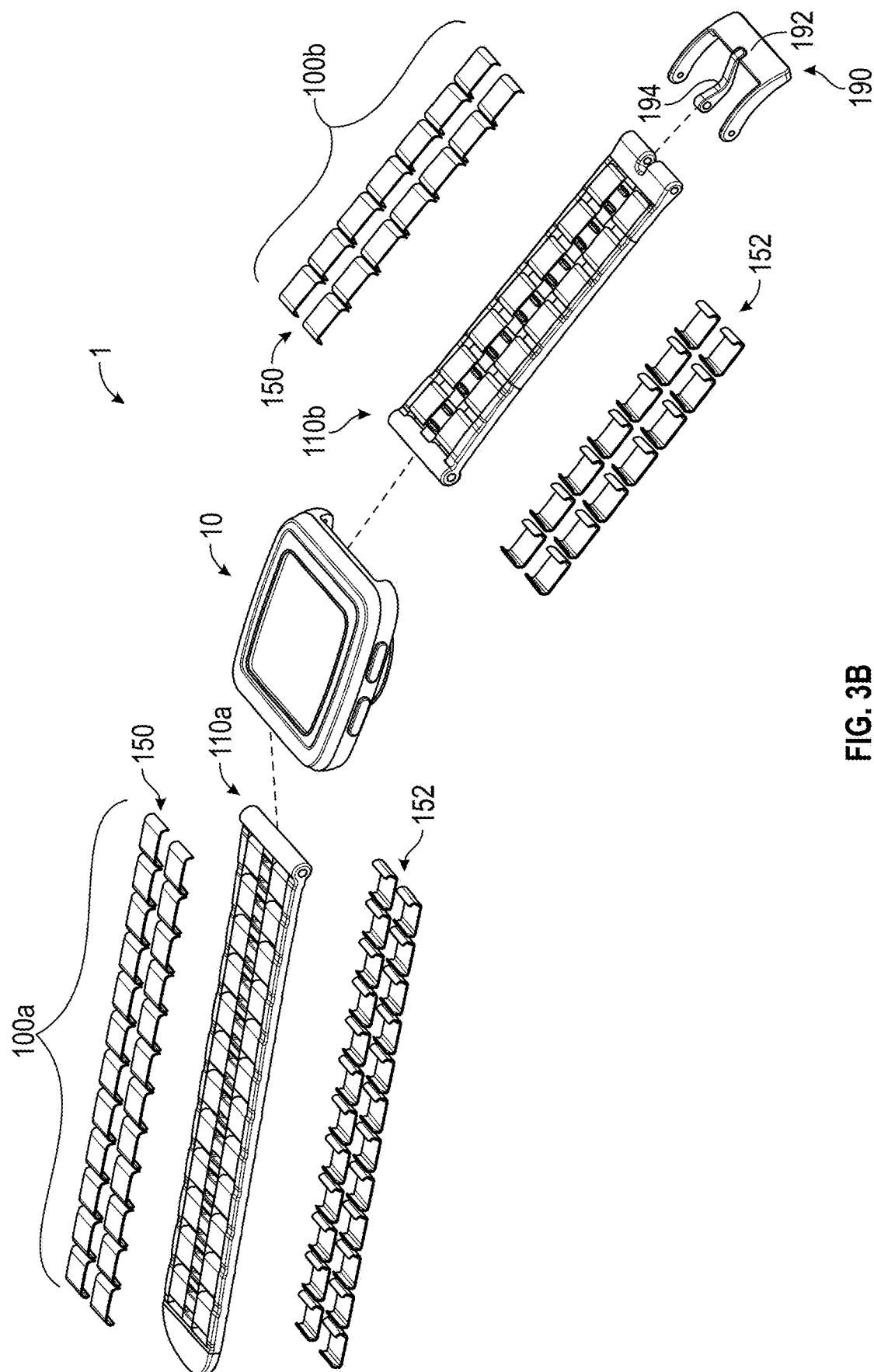


FIG. 3B

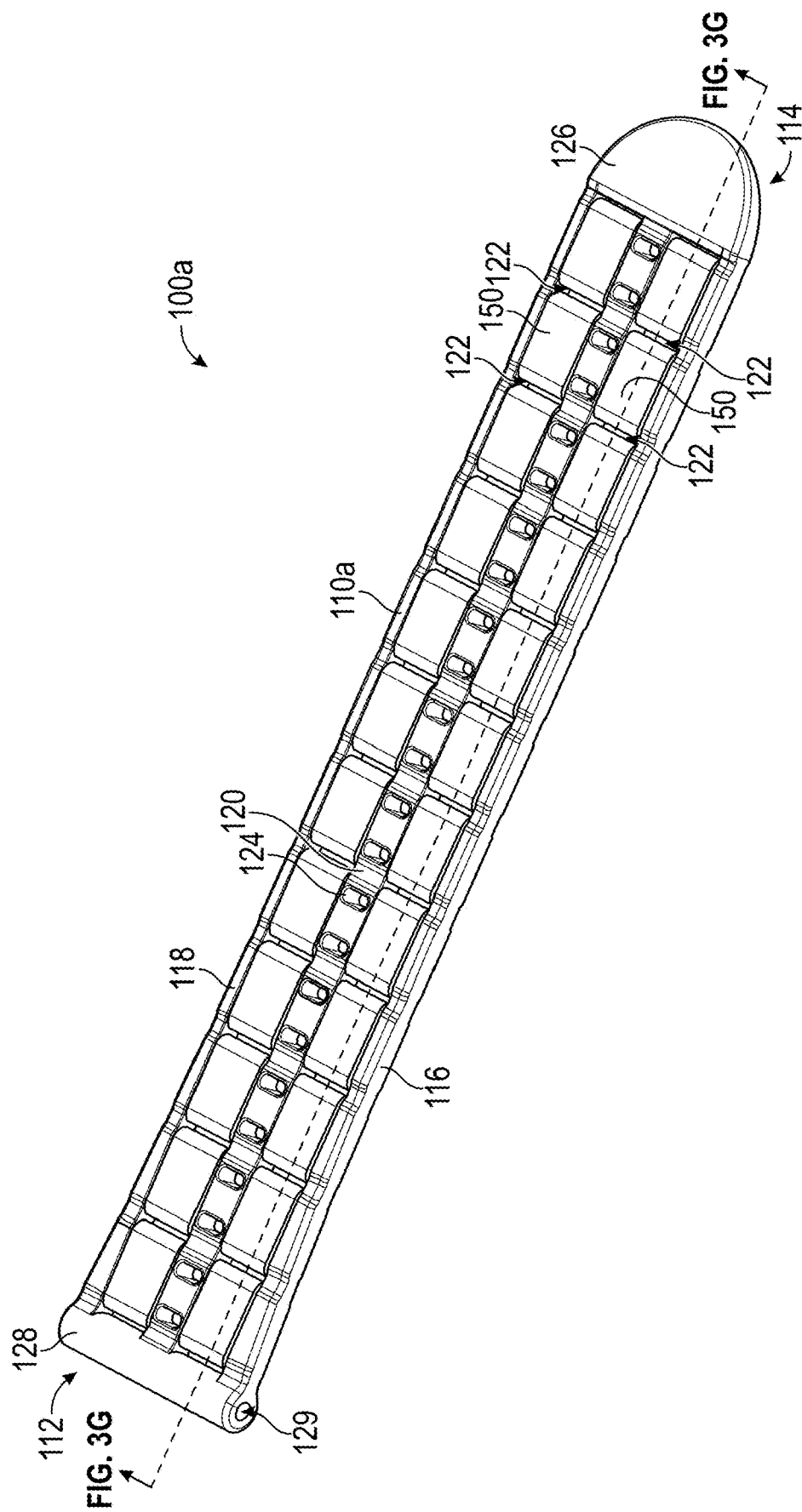


FIG. 3C

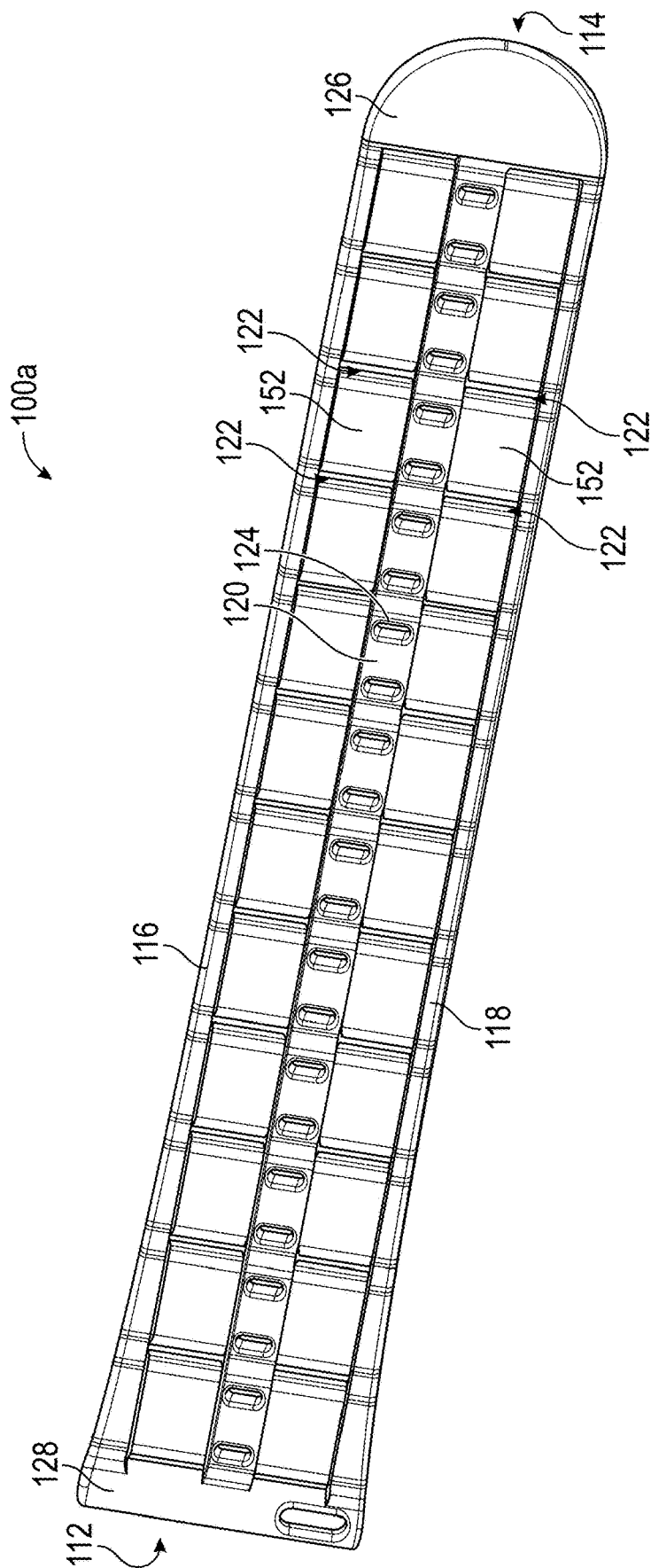


FIG. 3D

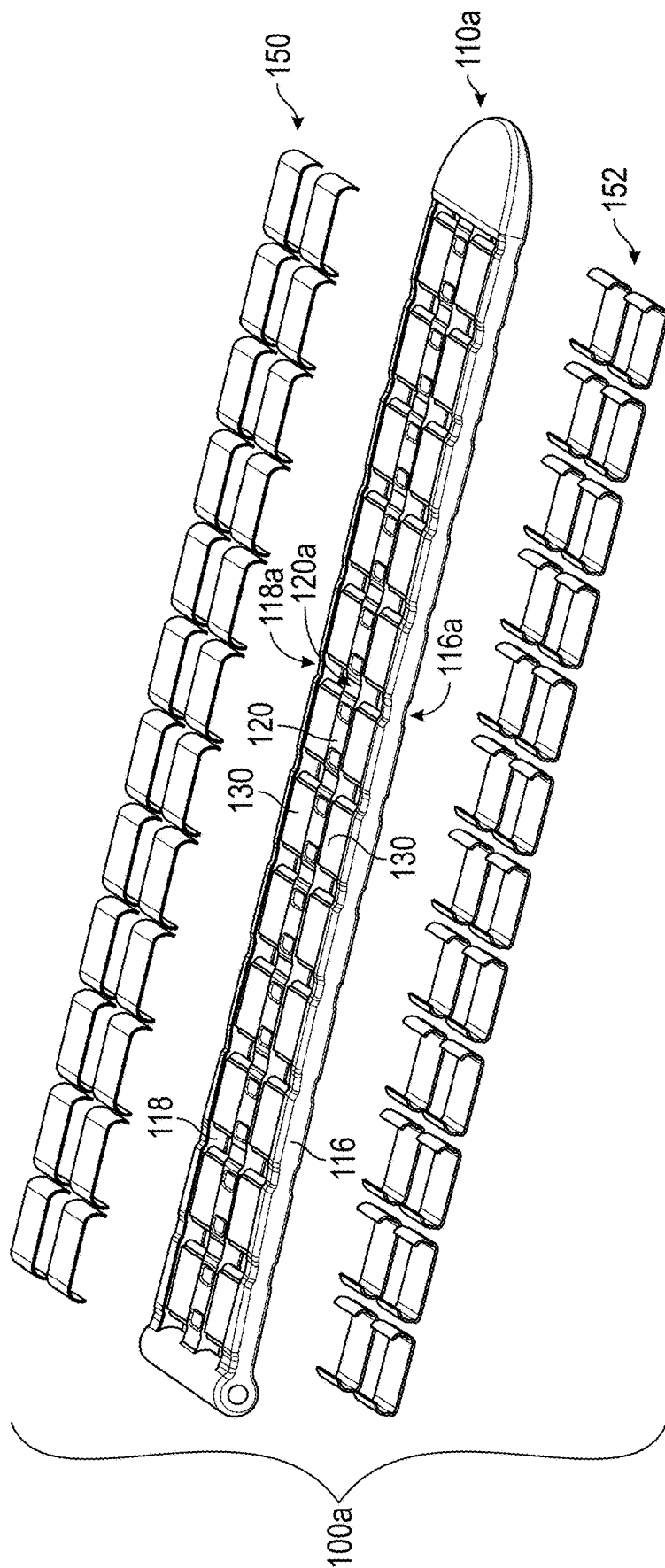


FIG. 3E

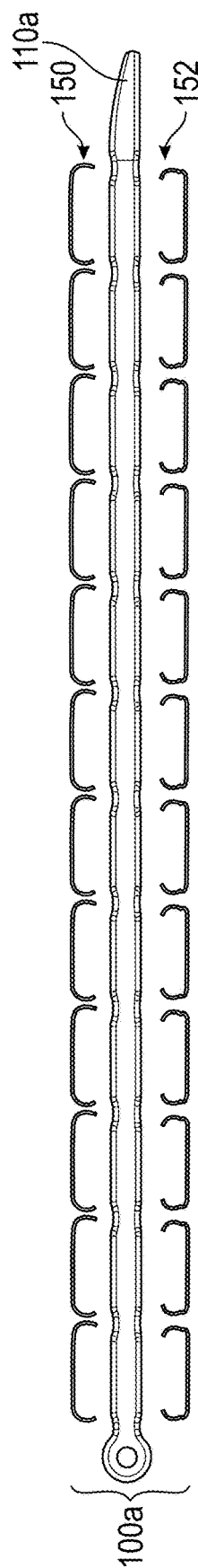


FIG. 3F

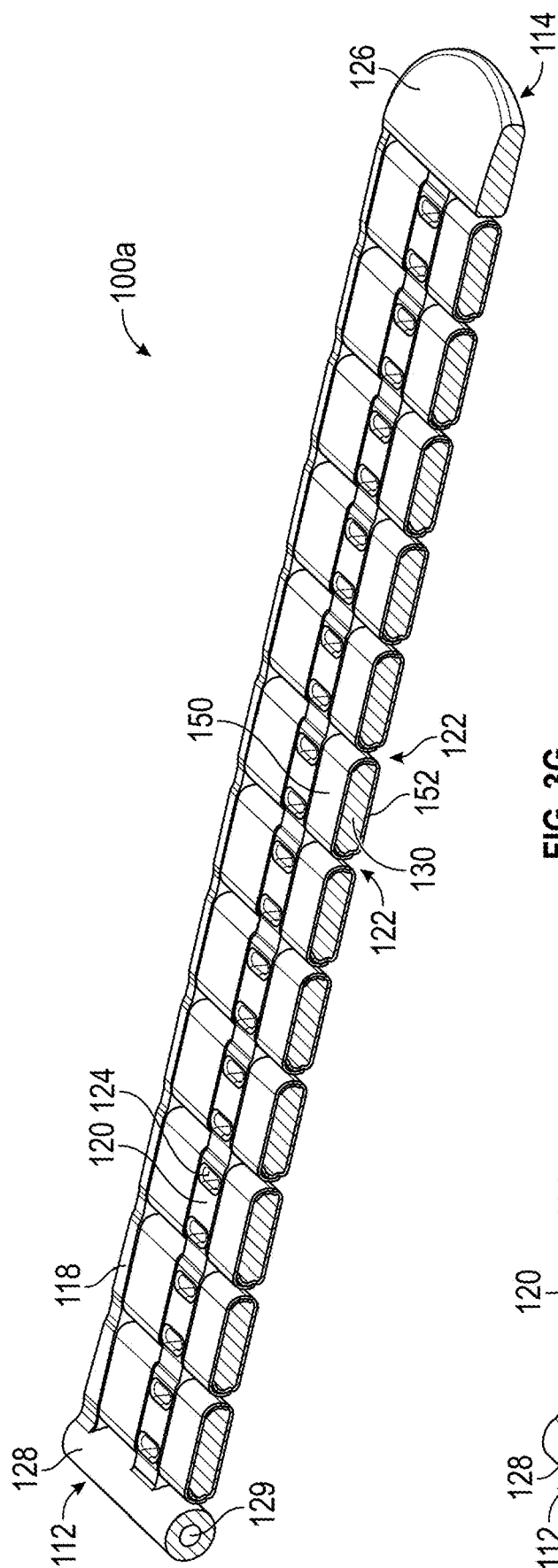


FIG. 3G

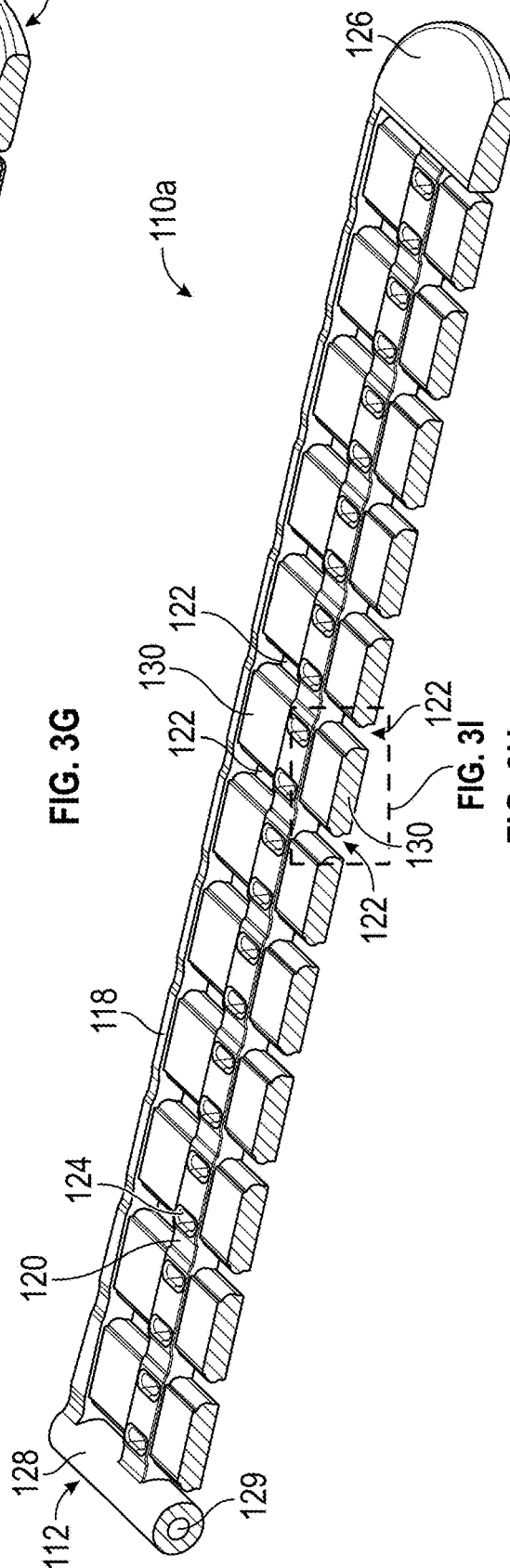


FIG. 3H

FIG. 3I

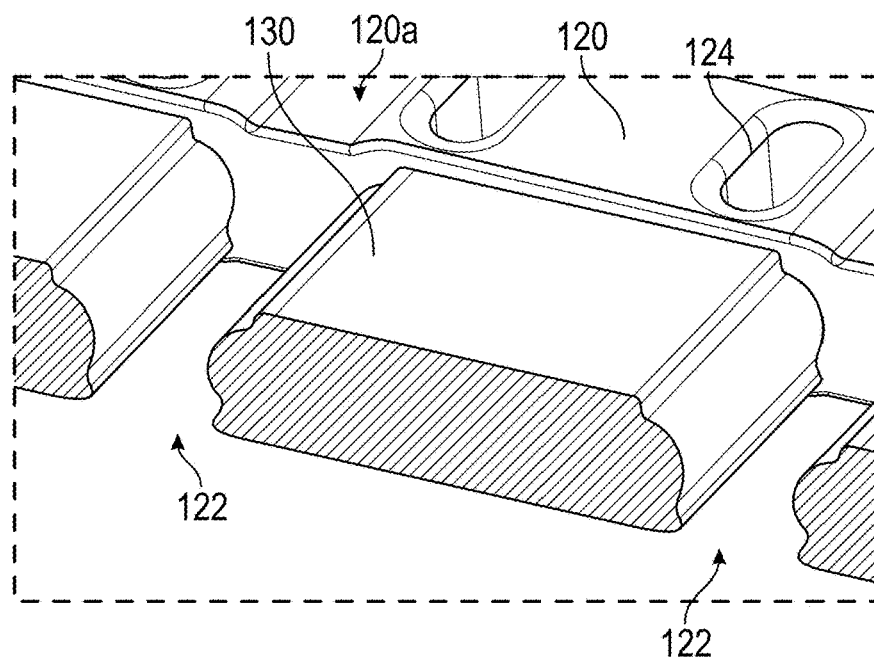


FIG. 3I

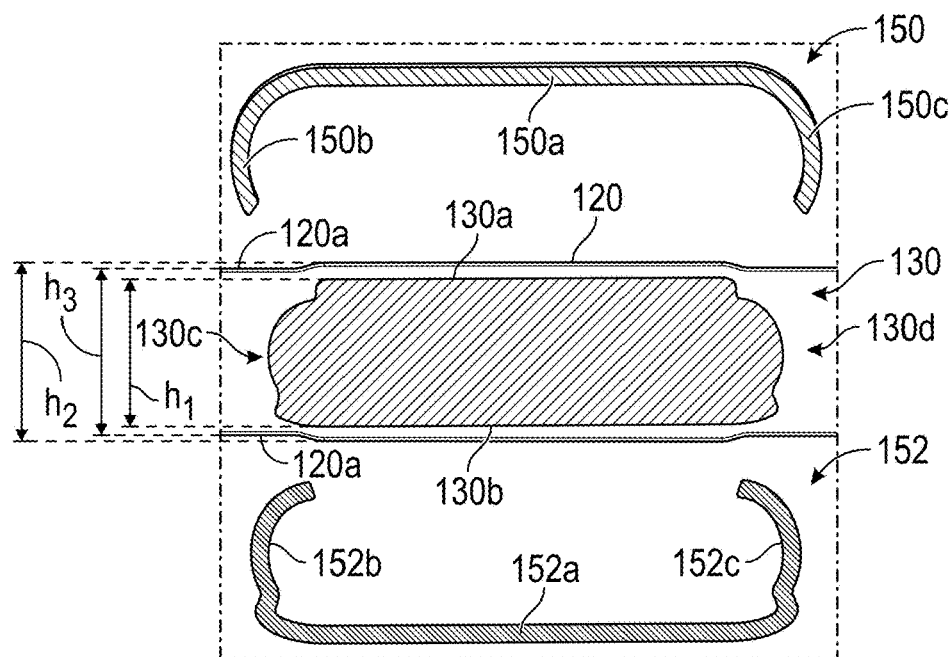


FIG. 3J

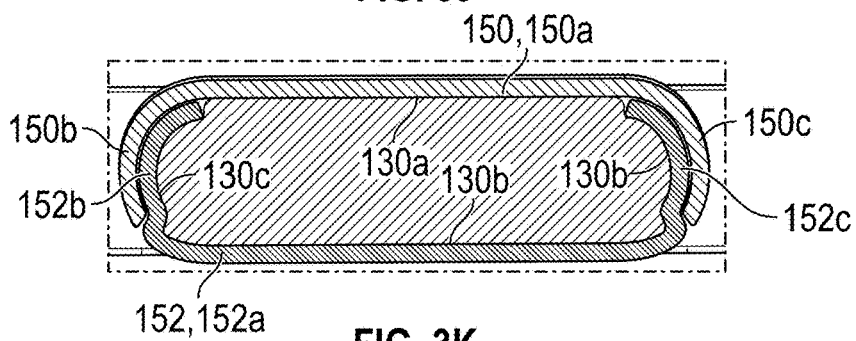


FIG. 3K

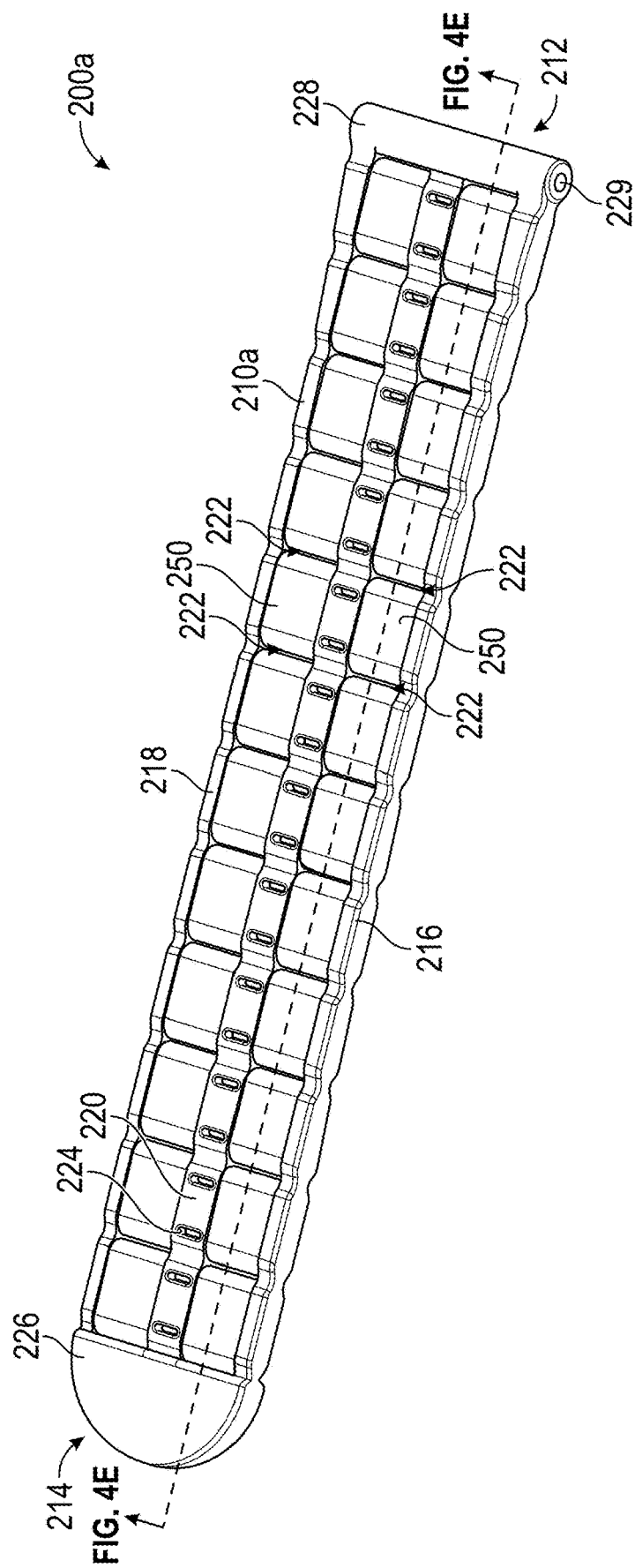


FIG. 4A

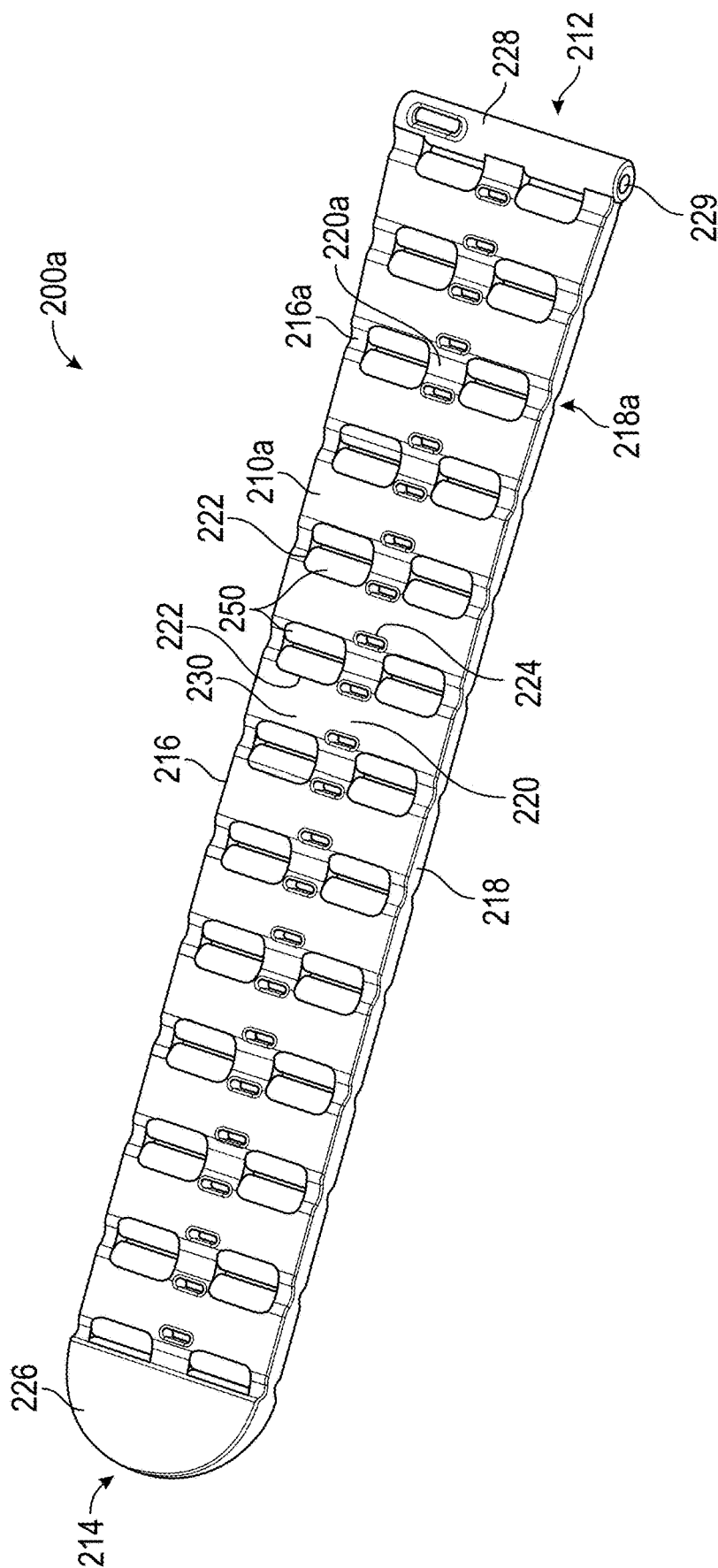


FIG. 4B

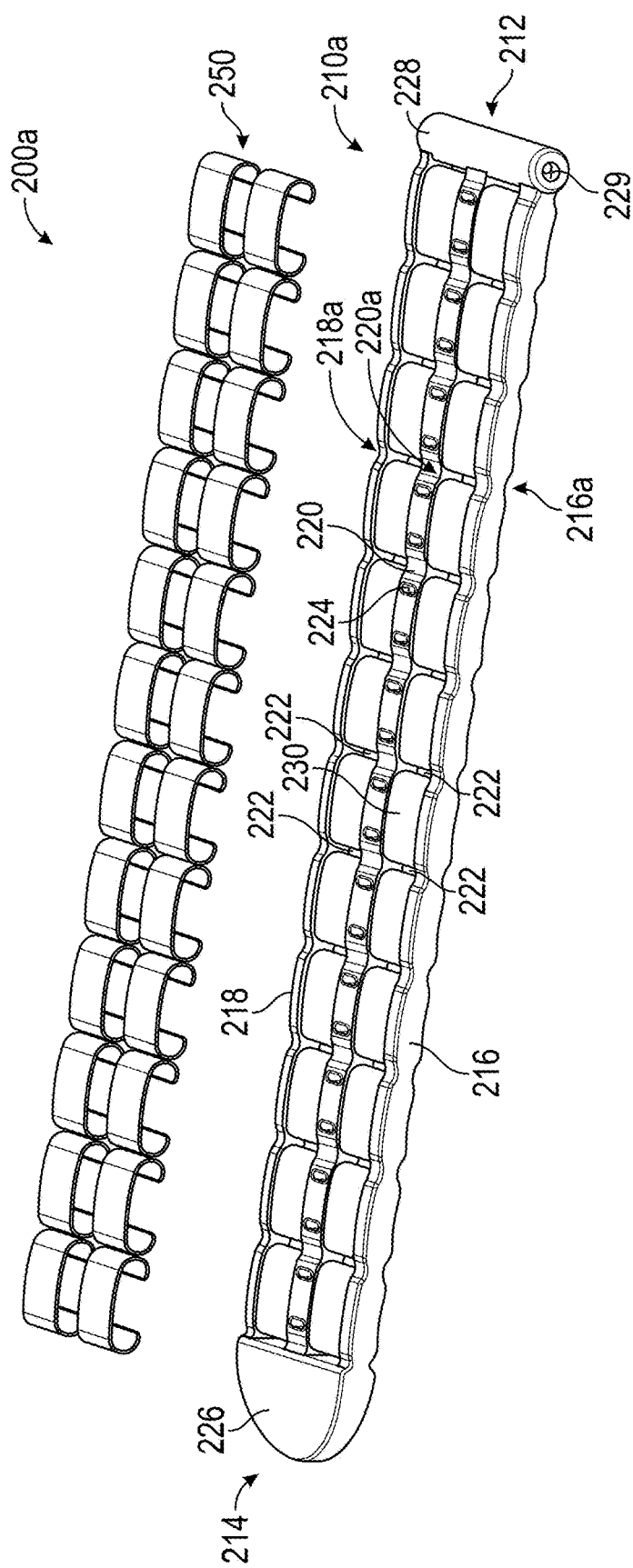


FIG. 4C

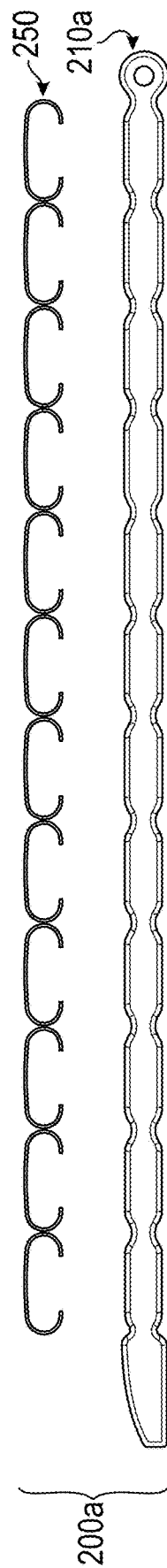


FIG. 4D

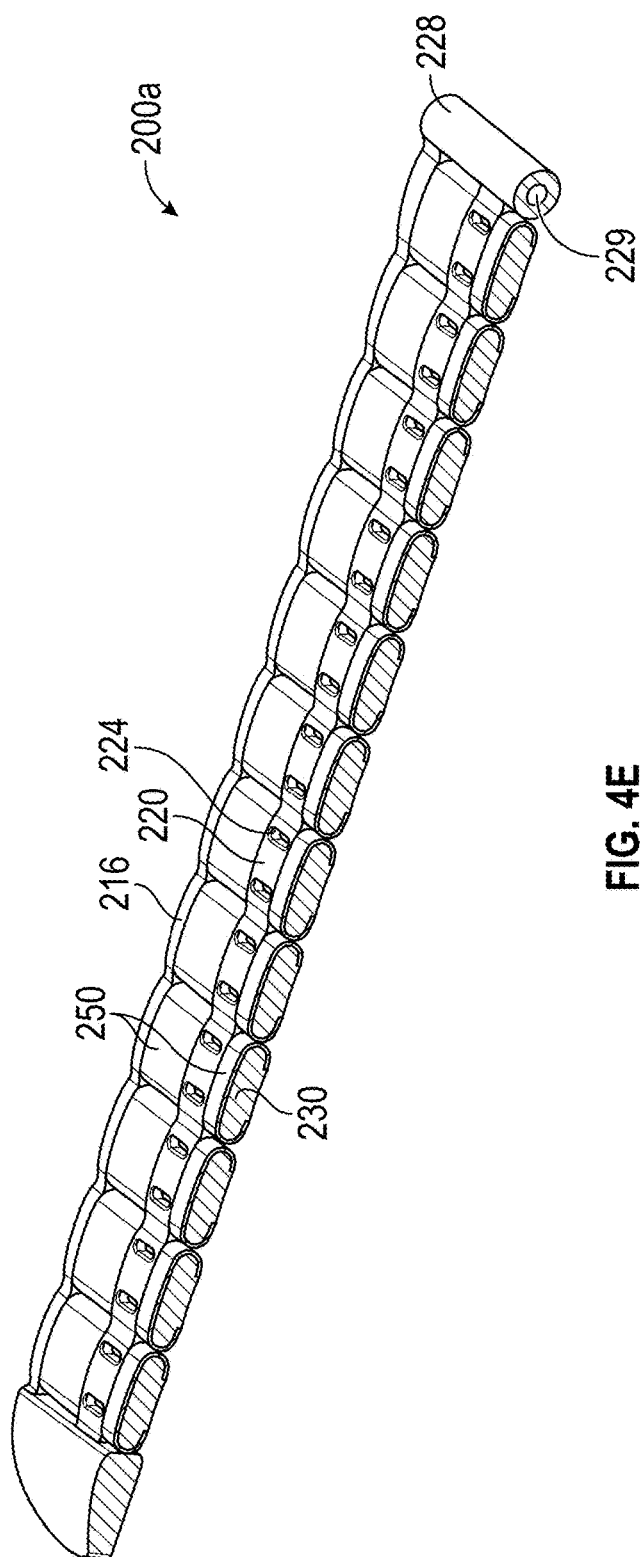


FIG. 4E

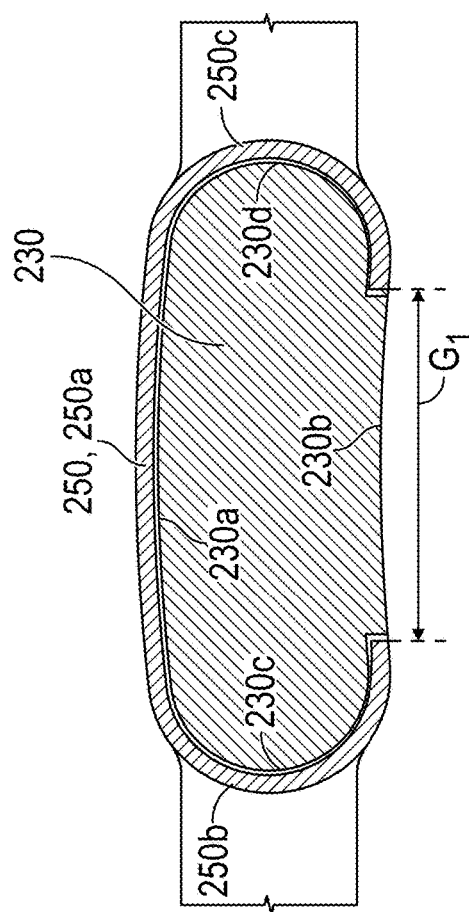


FIG. 4F

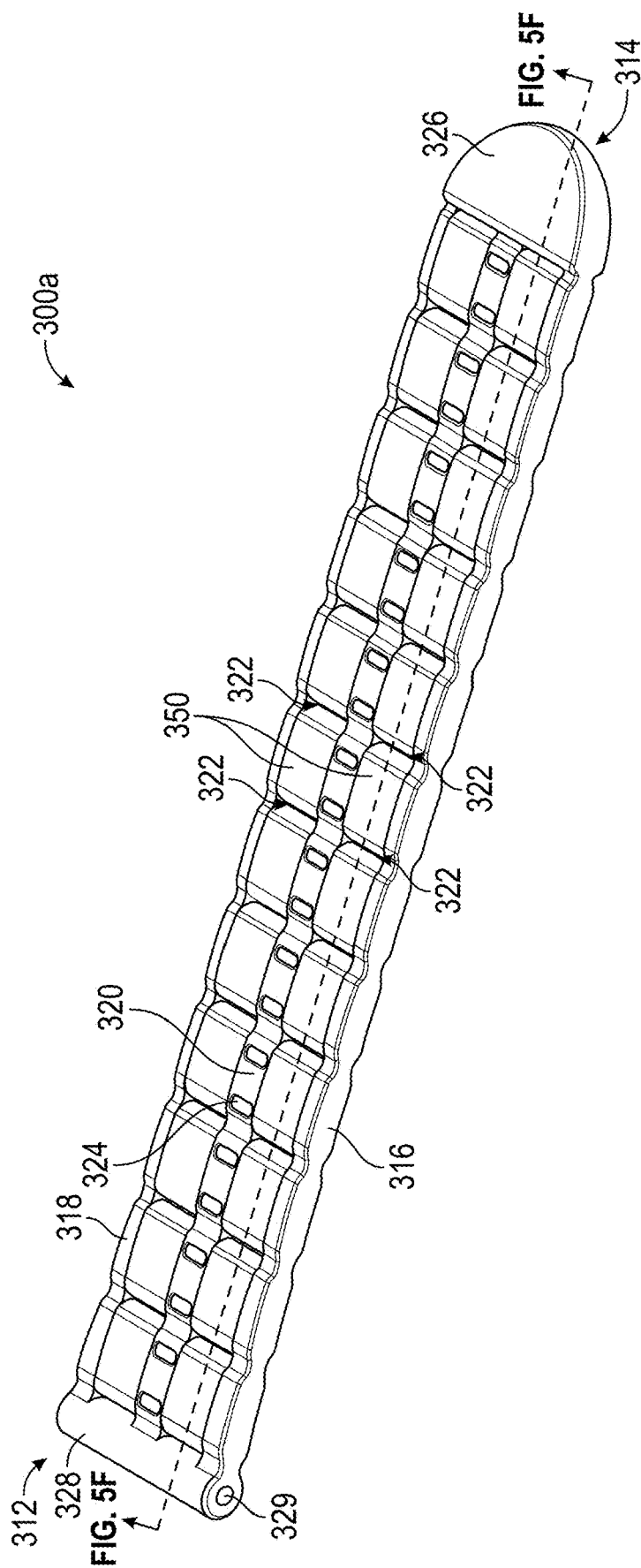


FIG. 5A

FIG. 5B

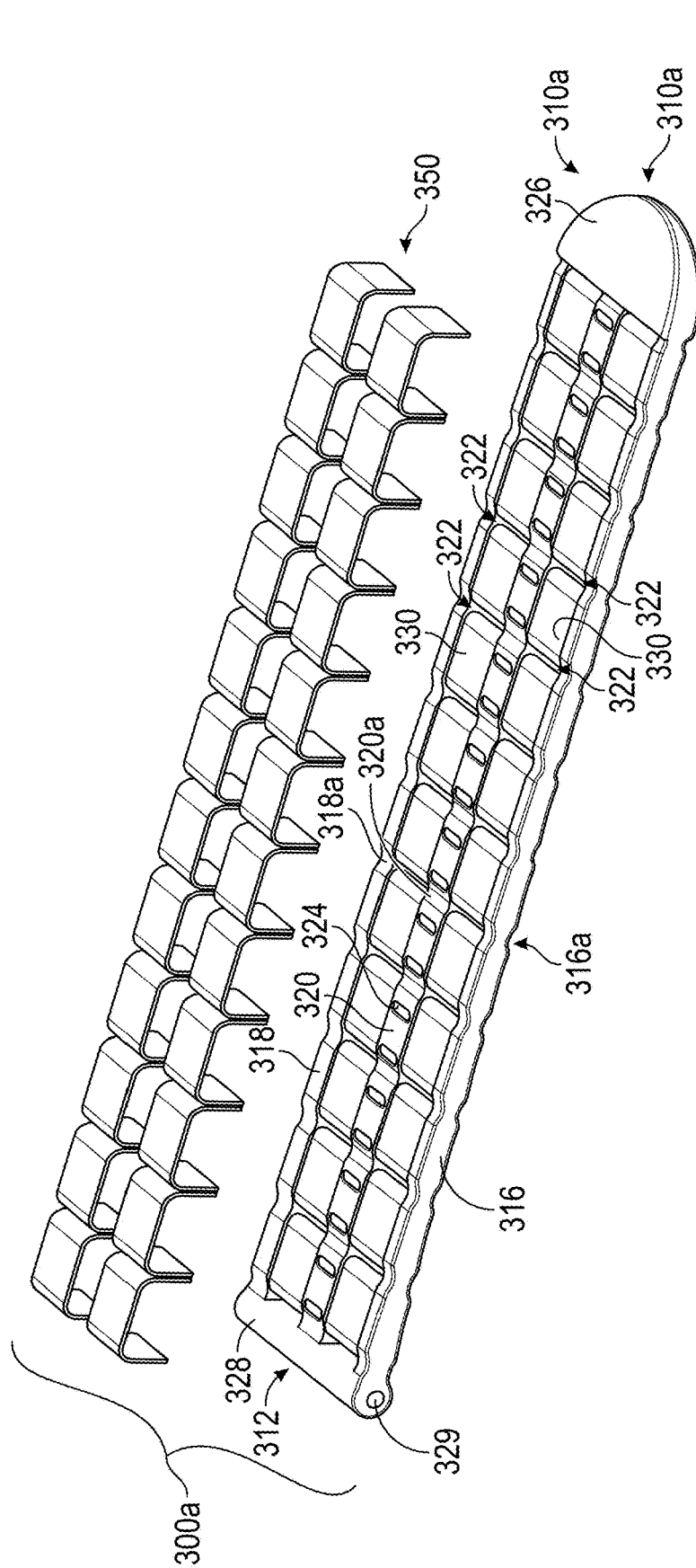


FIG. 5C

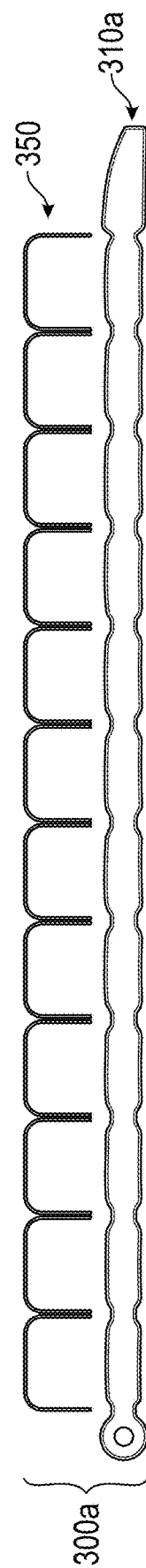
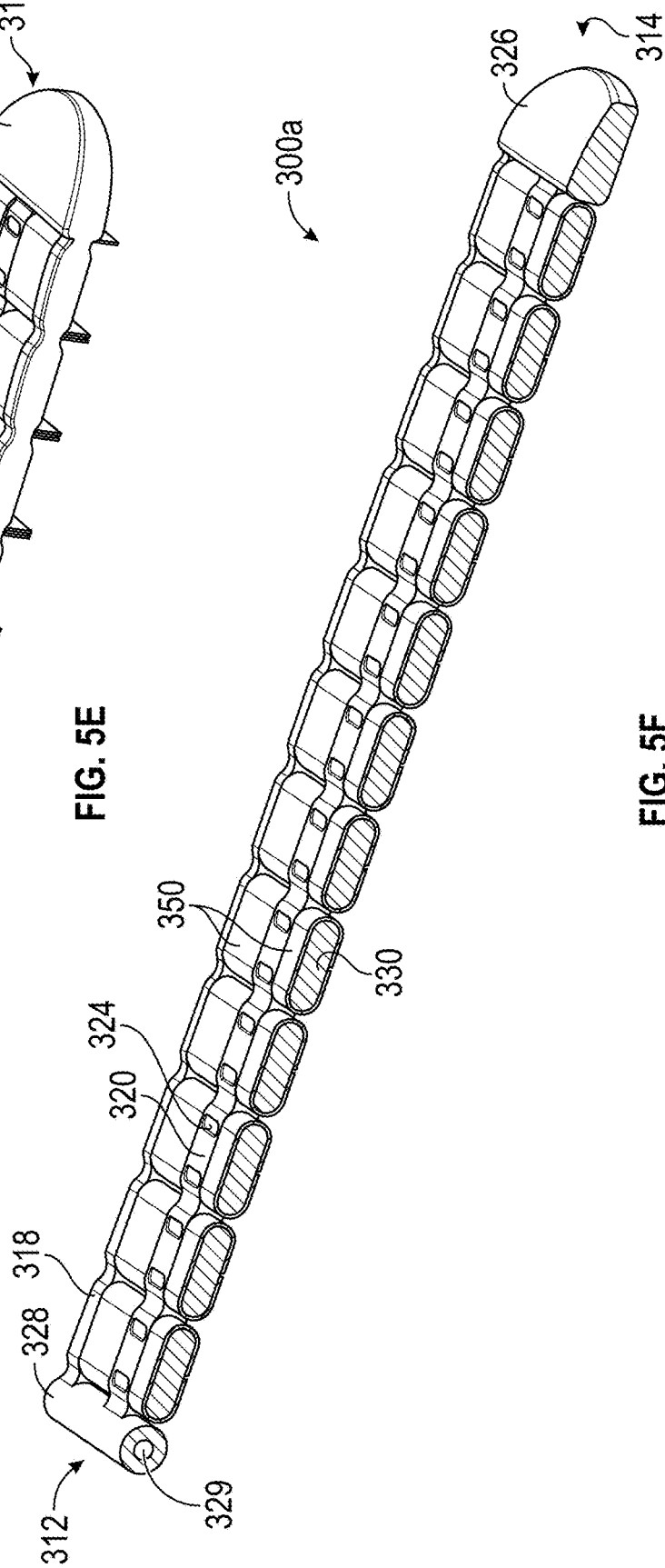
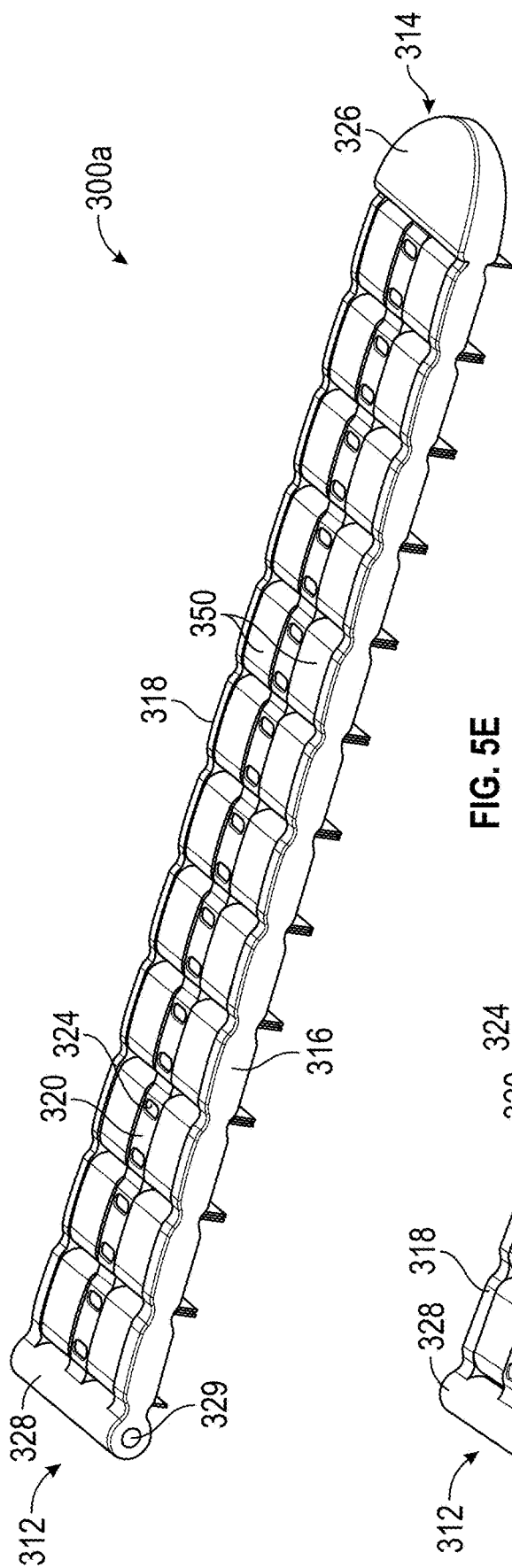


FIG. 5D



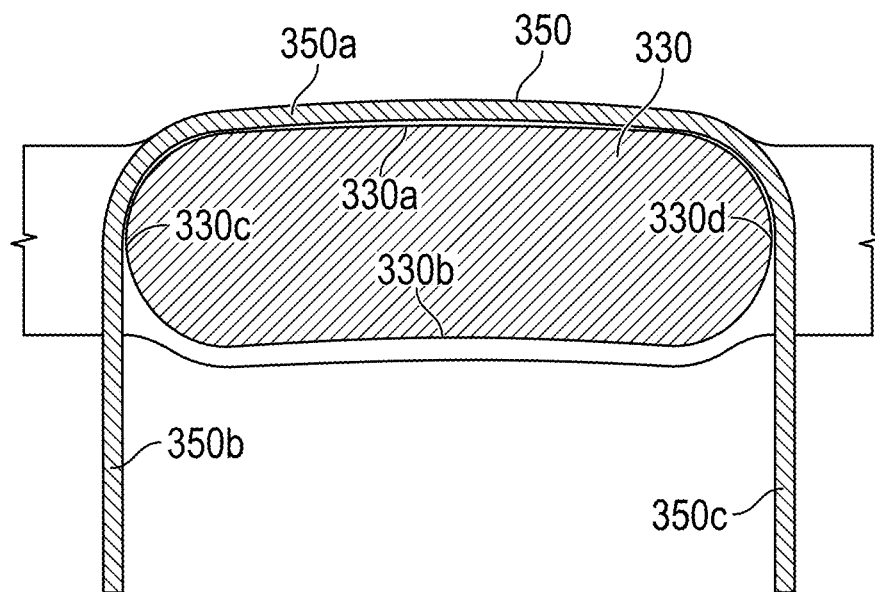


FIG. 5G

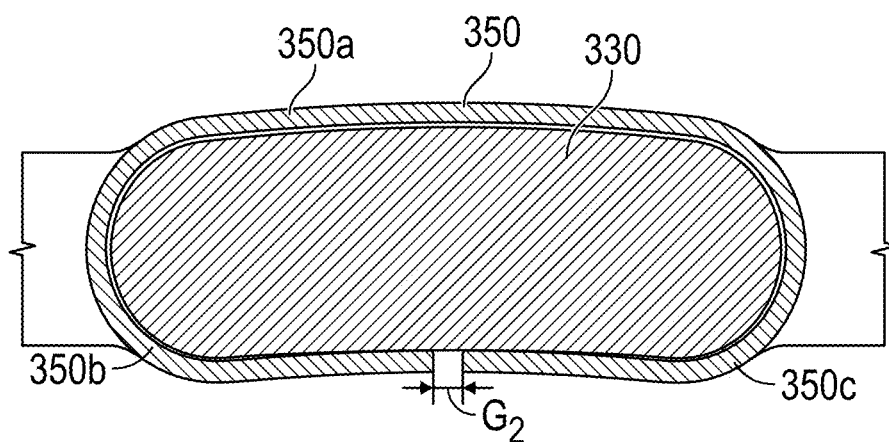


FIG. 5H

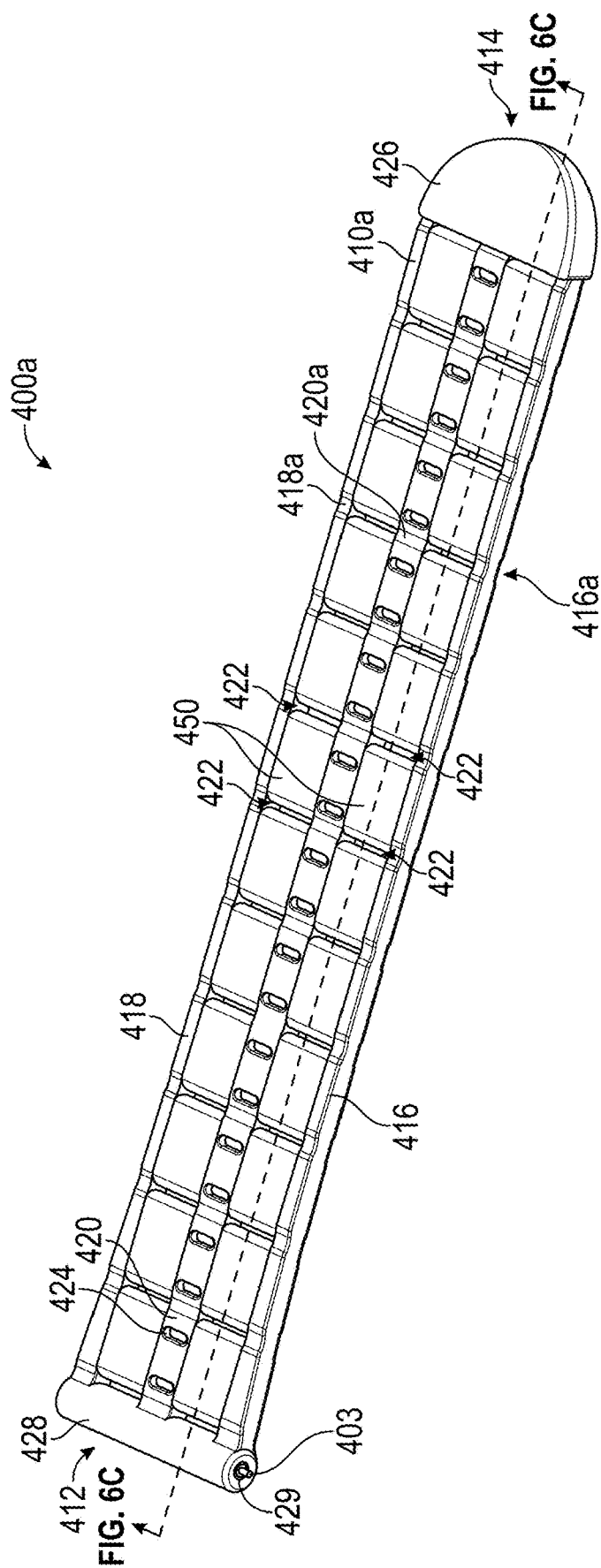


FIG. 6A

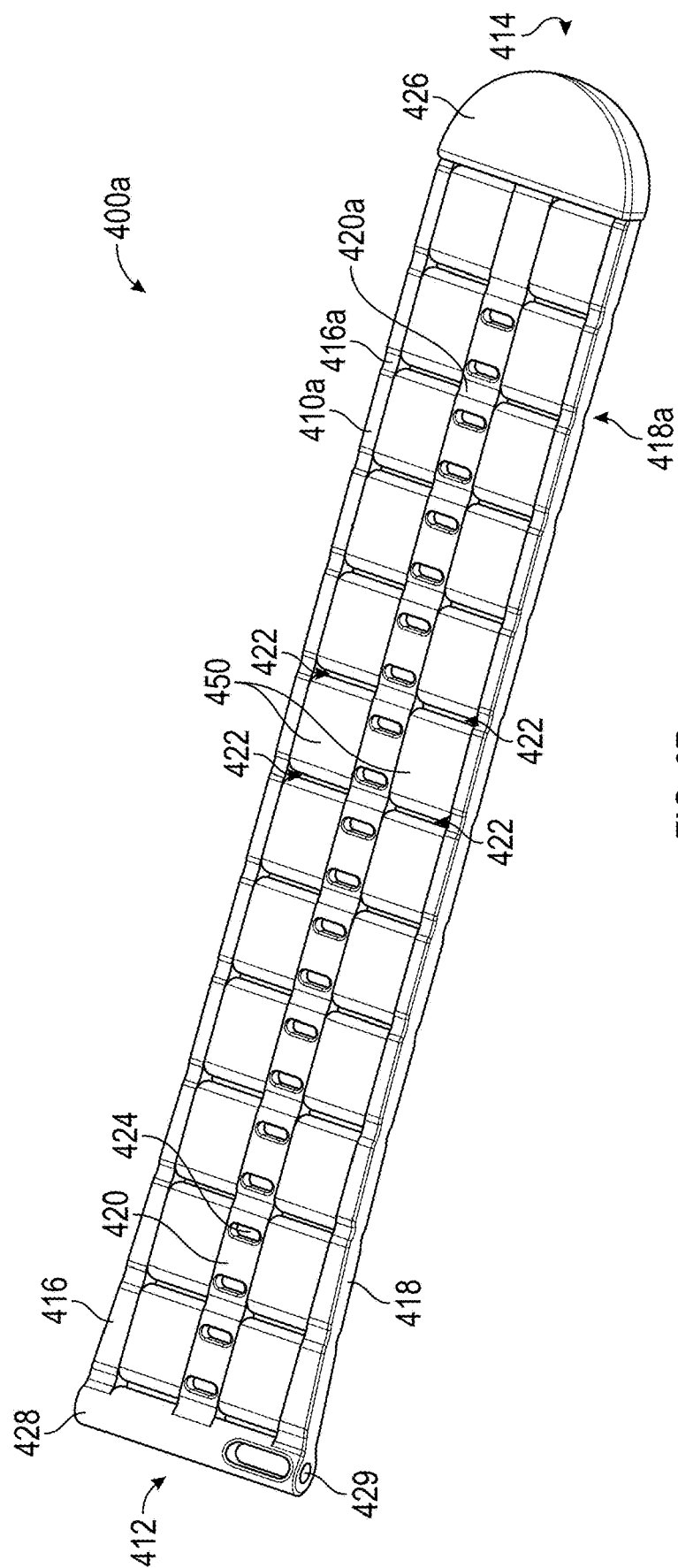


FIG. 6B

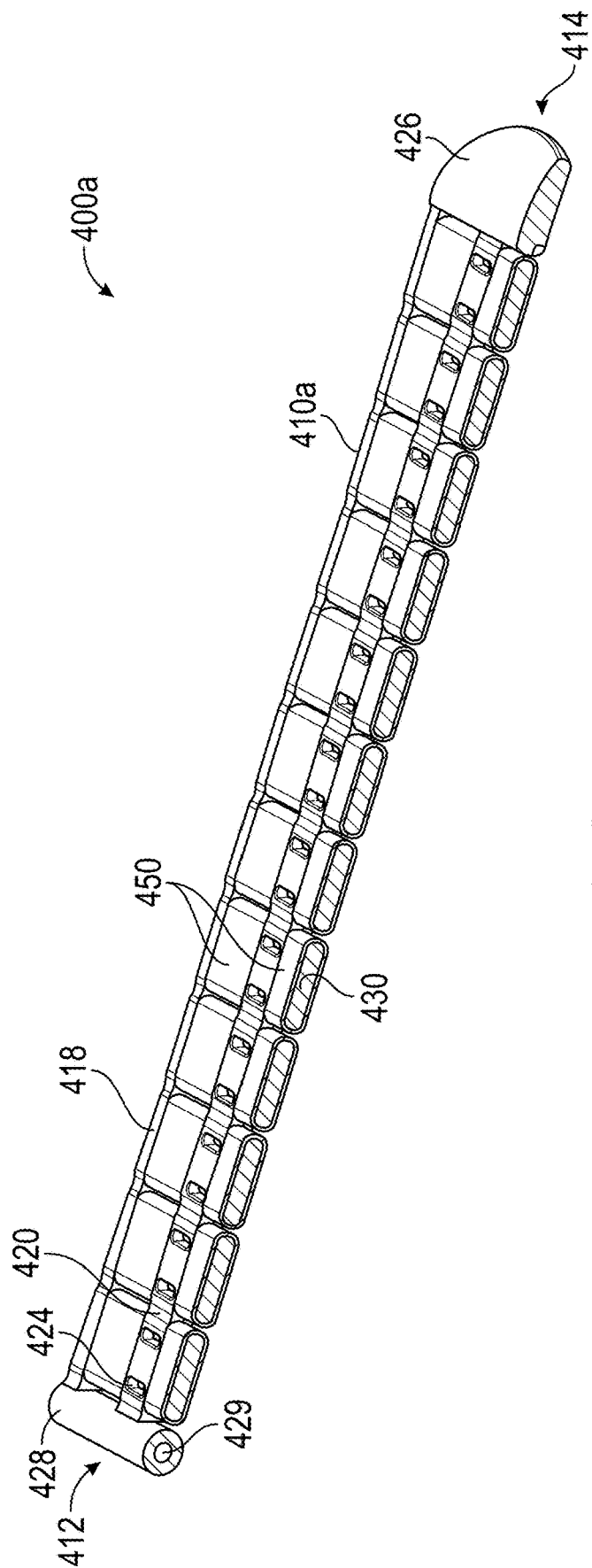


FIG. 6C

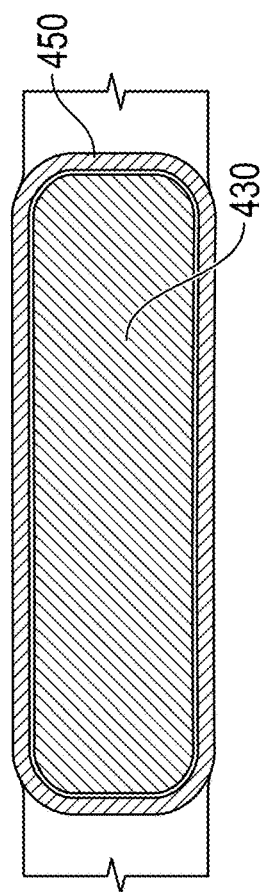


FIG. 6D

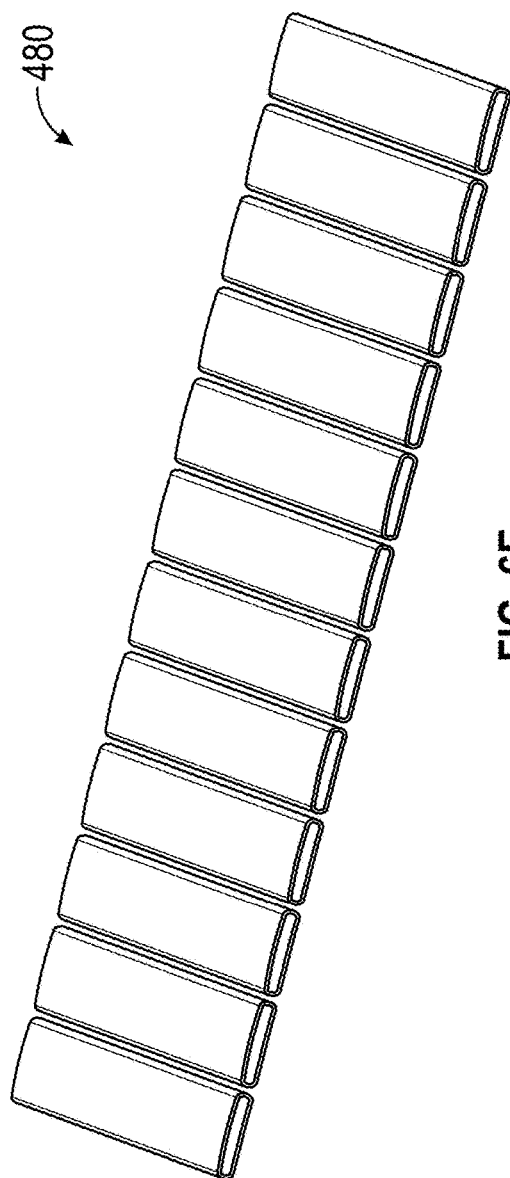


FIG. 6E

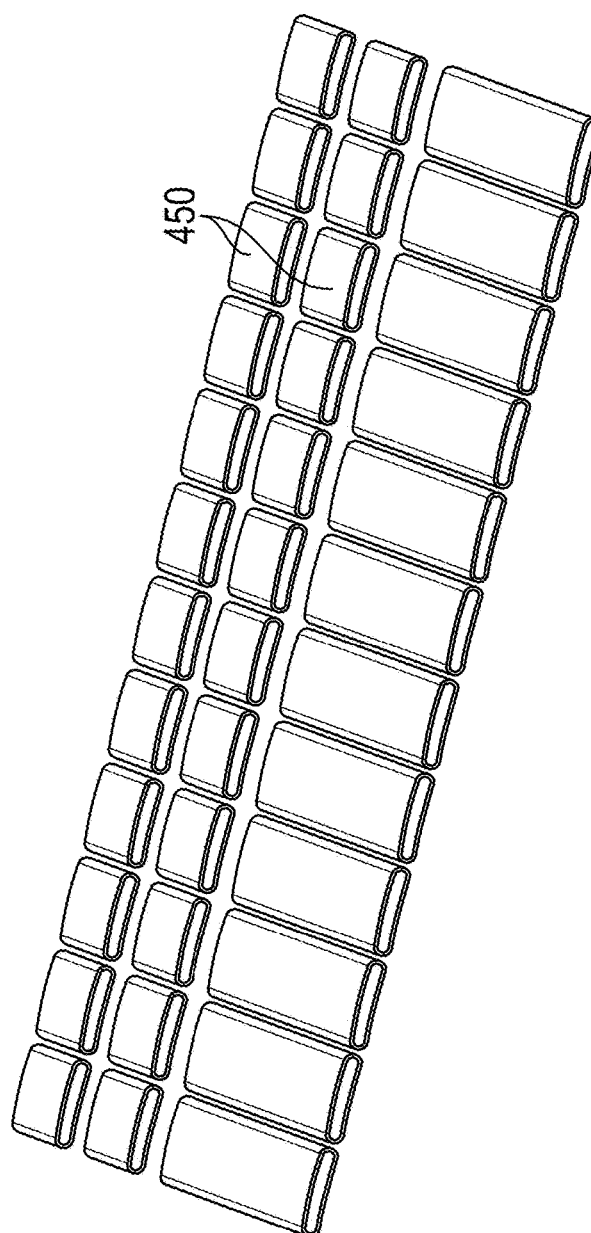


FIG. 6F

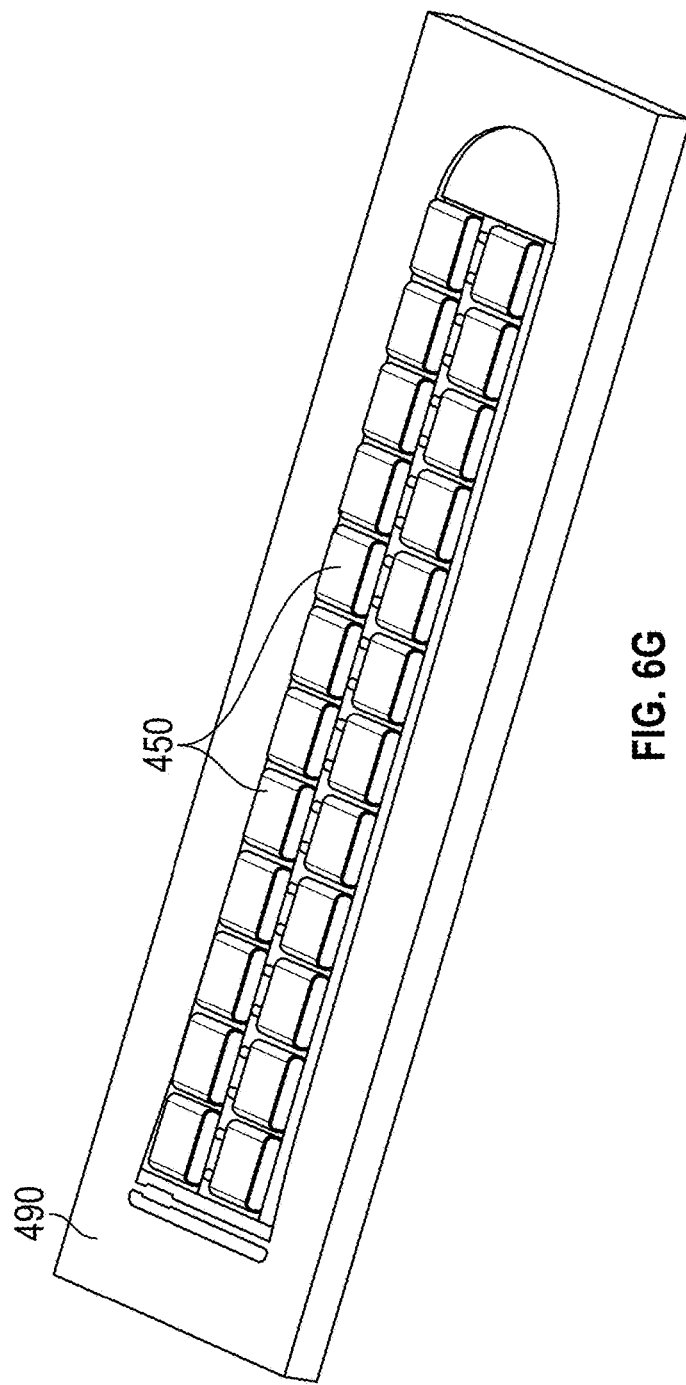


FIG. 6G

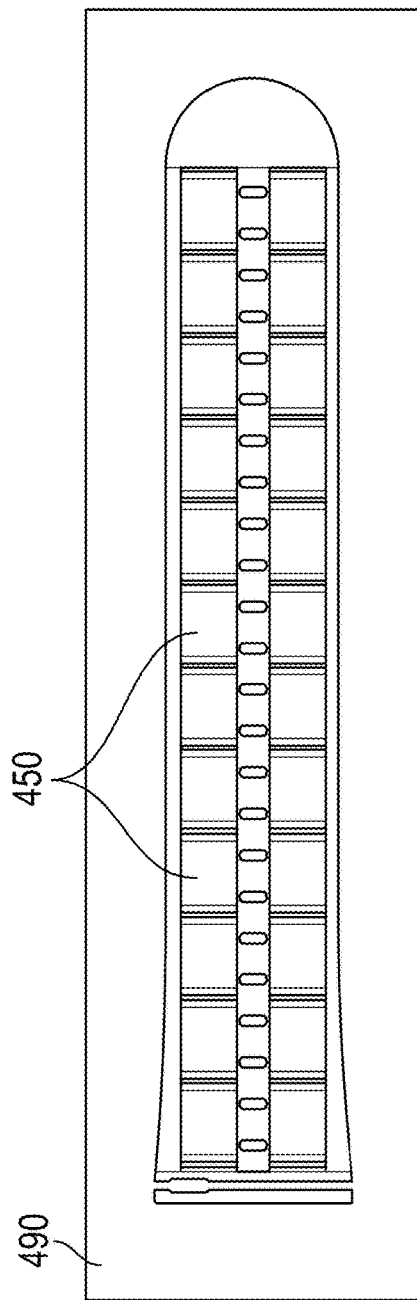


FIG. 6H

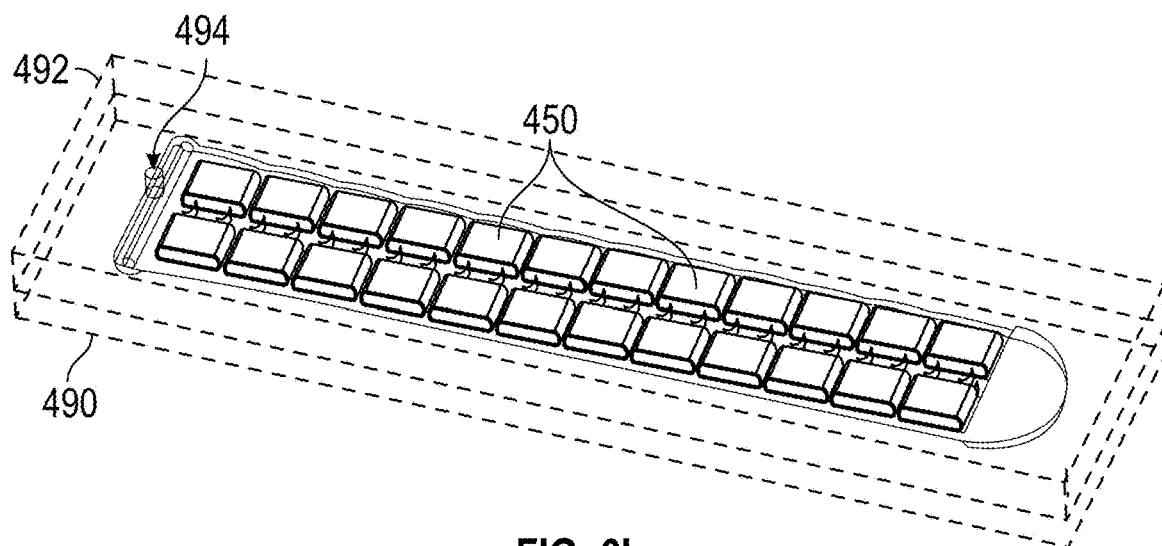


FIG. 6I

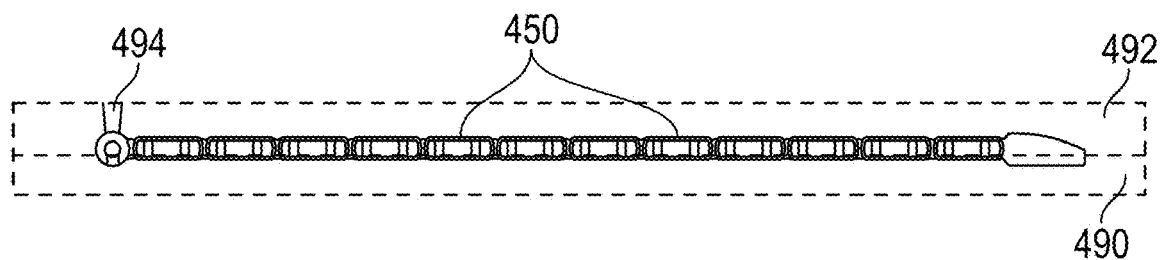


FIG. 6J

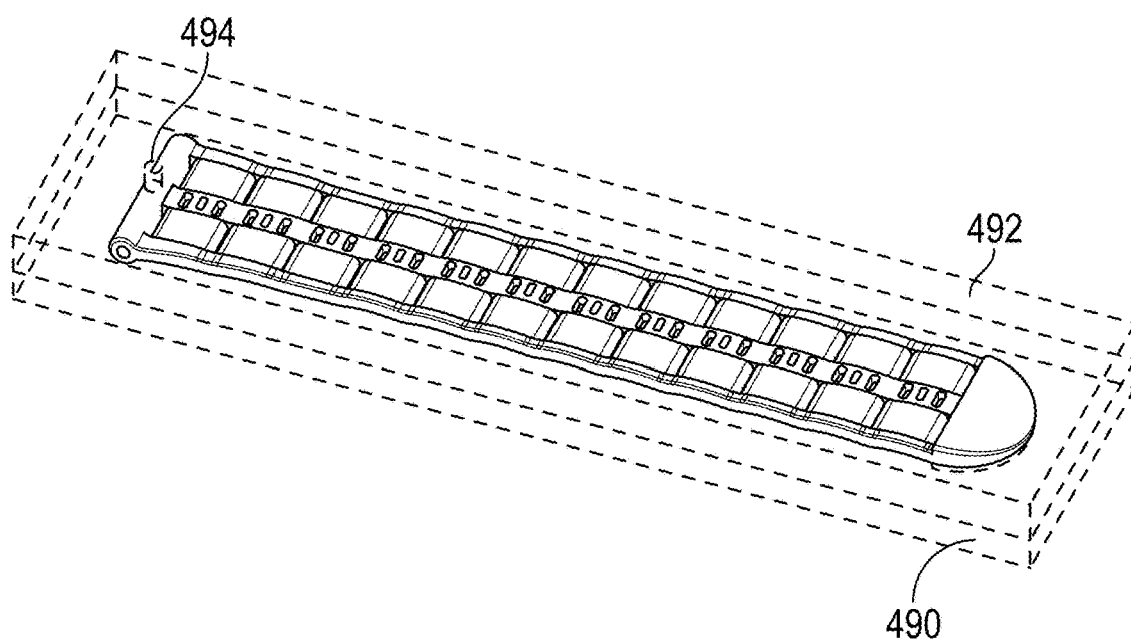


FIG. 6K

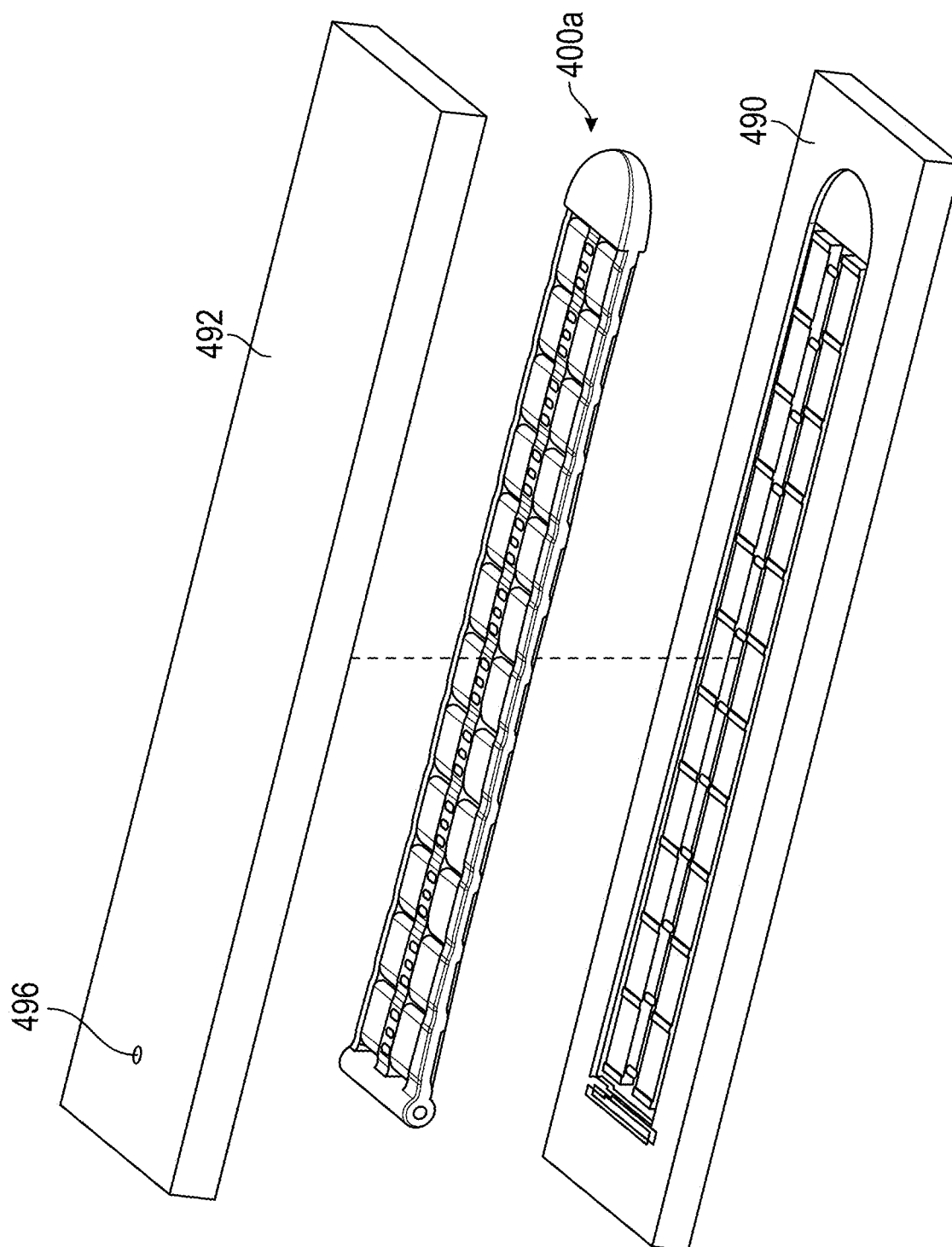


FIG. 6L

STRAP FOR A WEARABLE DEVICE

INCORPORATION BY REFERENCE TO ANY PRIORITY APPLICATIONS

[0001] This application claims the benefit of priority under 35 U.S.C. § 119(e) to U.S. Patent Application No. 63/068,256, entitled “WEARABLE PHYSIOLOGICAL MONITORING DEVICE WITH ADJUSTABLE STRAPS”, filed Aug. 20, 2020 and U.S. Patent Application No. 63/067,622, entitled “WEARABLE PHYSIOLOGICAL MONITORING DEVICE WITH ADJUSTABLE STRAPS” filed Aug. 19, 2020, all of which are hereby incorporated by reference herein in their entireties. Any and all applications for which a foreign or domestic priority claim is identified in the Application Data Sheet as filed with the present application are hereby incorporated by reference under 37 CFR 1.57.

FIELD

[0002] The present disclosure relates to straps for securing a wearable device, such as a wrist-worn health monitoring device, to a portion of a user's body, such as a wrist.

BACKGROUND

[0003] A patient monitoring device can include a pulse oximeter. The oximeter can calculate oxygen saturation (SpO_2), pulse rate, a plethysmograph waveform, perfusion index (PI), pleth variability index (PVI), methemoglobin (MetHb), carboxyhemoglobin (CoHb), total hemoglobin (tHb), glucose, and/or otherwise. The oximeter can display on one or more monitors the foregoing parameters individually, in groups, in trends, as combinations, or as an overall wellness or other index.

[0004] A pulse oximetry sensor is described in U.S. Pat. No. 6,088,607 entitled Low Noise Optical Probe; pulse oximetry signal processing is described in U.S. Pat. Nos. 6,650,917 and 6,699,194 entitled Signal Processing Apparatus and Signal Processing Apparatus and Method, respectively; a pulse oximeter monitor is described in U.S. Pat. No. 6,584,336 entitled Universal/Upgrading Pulse Oximeter; all of which are assigned to Masimo Corporation, Irvine, Calif., and each is incorporated by reference herein in its entirety.

SUMMARY

[0005] Monitoring of physiological parameters using pulse oximetry can be useful not only for patients in traditional hospital care settings, but also for individuals in the ordinary course of daily activities. Oximetry utilizes a noninvasive optical sensor to measure physiological parameters of a person. In general, the sensor has light emitting diodes (LEDs) that transmit optical radiation into a tissue site and one or more detectors that detect the optical radiation after absorption (by transmission, reflectance, or transreflectance) by, for example, pulsatile arterial blood flowing within the tissue site. Based on the detected optical radiation, a processor can determine measurements for peripheral oxygen saturation (SpO_2), which is an estimate of the percentage of oxygen bound to hemoglobin in the blood, pulse rate, plethysmograph waveforms, which indicate changes in the volume of arterial blood with each pulse beat, and perfusion quality index (for example, an index that quantifies pulse strength at the sensor site), among many others.

[0006] A physiological monitoring module, also referred to herein as a plethysmograph module or a module, can be incorporated in a wearable device that is secured to a portion of a person's body, such as a wrist of a person (the “wearer”). Such wearable device can be a watch, for example. The module on the watch can be used to monitor one or more physiological parameters of the wearer. The module can detect pulse rate, oxygen saturation, and/or other physiological parameters, such as any of those disclosed elsewhere herein. The module can include a curvature to improve pressure and contact, and therefore optical coupling, between the wearer's skin and the plethysmograph module. The curvature of the module can be designed to balance pressure of the watch on the wearer's wrist and the wearer's comfort. In some implementations, the module and/or the watch can include a connection port to receive another pulse oximeter sensor configured to be coupled to the wearer at a different measurement site of the wearer's body than the wrist.

[0007] Some wearable devices which include components and/or functionality configured to allow measurement of physiological parameters of a user secure to the user via one or more straps. The amount of pressure and/or contact applied by the wearable device when associated straps are secured to the wearer can have a significant affect on the integrity of the physiological parameter measurements obtained by the wearable device. Accordingly, it is desirable to ensure that the straps which secure the wearable device facilitate good pressure and/or contact with the wearer's skin. At the same time, however, wearer comfort is an important consideration. If the straps and/or wearable device are configured such that good pressure and/or contact between the wearable device and the wearer's skin causes discomfort for the wearer, the wearer may only be able to wear the wearable device for short periods of time and/or may loosen the strap(s) in a manner which may impair the integrity of physiological measurements obtained by the wearable device. Some conventional straps for wearable devices are made only of a pliable material which, while providing some comfort to the user, may be allowed to flex and/or stretch too much, thereby impairing the integrity of physiological measurements obtained by the wearable device coupled with the straps. Further, the material of such conventional straps may be rough and/or otherwise uncomfortable to the wearer, especially over long periods of time.

[0008] In various implementations, the present disclosure describes straps for securing a wearable device to a user that are made of metal and also with a more pliable material (for example, a more stretchable material) to facilitate both robust physiological parameter measurements and user comfort. For example, various implementations of the straps disclosed herein incorporate metal (for example, a plurality of metal parts and/or sections) and a different material that is more pliable (for example, more stretchable) than metal, such as a material comprising rubber and/or silicone. In some implementations, a majority (for example, greater than 50%, 55%, 60%) of the strap comprises a non-metallic material, such as rubber and/or silicone. In some implementations, less than half of the strap comprises a metallic material (such as stainless steel). In some implementations, at least half of the strap comprises a non-metallic material, such as rubber and/or silicone. In some implementations, a majority (for example, greater than 50%) of a portion of the strap that contacts the user's skin when the wearable device

and/or strap is in use comprises a metallic material, for example, a smooth metallic material. Such configurations can increase user comfort since the metallic material can facilitate a smooth contact surface with the wearer's skin. Such configurations can also facilitate greater user comfort at the skin-contact interface in comparison to straps made entirely of a non-metallic material such as rubber or leather, especially when the straps are in use for long periods of time. Various implementations of the straps disclosed herein incorporate openings along a length and/or width of the strap which can, among other things, allow air to reach skin proximate the straps and facilitate breathability. Such openings can be separate from holes along portions of the strap which are configured to receive a buckle tongue of a corresponding strap to form a closed loop around a portion of the wearer's body (for example, wrist). Advantageously, various implementations of the straps disclosed herein incorporate metal and a non-metallic material (for example, silicone and/or rubber) to facilitate optimal pressure and/or contact with the wearer's skin and thus increased accuracy in physiological parameter measurements and increased comfort.

[0009] In various implementations, the present disclosure describes straps that do not comprise metal links that join portions of the strap together. In some implementations, the disclosed straps include one or more or a plurality of living hinges in non-metallic portions of the straps, such as in and/or along edge members of the straps which can define sides of the straps. Such living hinges can be spaced apart from one another. In some implementations, such living hinges are formed by narrowing portions of such edge members.

[0010] Disclosed herein is a strap for a wearable device configured to secure to a portion of a body of a user. In some implementations, the strap comprises: a base comprising a first material; and a plurality of strap members positioned around portions of the base along a length of the base, each of the plurality of strap members comprising a second material, wherein the first material of the base is more pliable than the second material of each of the plurality of strap members.

[0011] In some implementations, the base comprises an integrally molded structure. In some implementations, the first material comprises at least one of rubber and silicone. In some implementations, the second material comprises metal. In some implementations, the second material comprises stainless steel. In some implementations, the plurality of strap members limit an ability of the base to stretch along an axis generally parallel to the length of the base. In some implementations, portions of the plurality of strap members are configured to contact skin of the user when the strap is secured to the user's wrist in use. In some implementations, said portions of the plurality of strap members are smooth.

[0012] In some implementations, an amount of the strap that is comprised by the base is greater than an amount of the strap that is comprised by the plurality of strap members. In some implementations, the plurality of strap members are configured to surround said portions of the base. In some implementations, the plurality of strap members do not comprise an integrally formed structure.

[0013] In some implementations, the base further comprises a first end configured to connect to a first portion of the wearable device and a second end opposite the first end, and wherein the length of the base extends between the first

and second ends. In some implementations, the plurality of strap members are spaced from the first end and the second end of the base. In some implementations, the base further comprises a width extending between opposite sides of the base, and wherein the plurality of strap members are inset from the sides of the base between said width.

[0014] In some implementations: the base further comprises: a first end configured to connect to a portion of the wearable device; a second end opposite the first end, wherein said length extends between the first and second ends; a width extending between opposite sides of the base; a plurality of openings spaced from one another along the length; and a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width; and the plurality of strap members comprises a plurality of channels positioned at least partially around the plurality of stems of the base. In some implementations, each of said plurality of channels comprises a web and at least one leg extending from the web, and wherein the web and the at least one leg are configured to surround a portion of one of the plurality of stems.

[0015] In some implementations, each of said plurality of channels comprises said web and two legs extending from the web. In some implementations, said legs are curved. In some implementations, said web is substantially planar. In some implementations, said web is curved. In some implementations, said two legs extend from opposite ends of the web. In some implementations, said web and said two legs are configured to surround less than an entirety of a cross-section of the one of the plurality of stems. In some implementations, said web and said two legs are configured to surround an entirety of a cross-section of the one of the plurality of stems.

[0016] In some implementations, said plurality of channels comprises a plurality of pairs of channels secured at least partially around the plurality of stems of the base. In some implementations, each of the plurality of pairs of channels comprises: a first channel configured to surround a first portion of one of the plurality of stems; and a second channel configured to surround a second portion of the one of the plurality of stems. In some implementations, the first channel member is configured to surround less than an entirety of a cross-section of the one of the plurality of stems. In some implementations, the second channel member is configured to surround less than said entirety of said cross-section of the one of the plurality of stems.

[0017] In some implementations, the first and second channels cooperate to surround an entirety of a cross-section of the one of the one of the plurality of stems. In some implementations, the first channel is configured to surround at least half of a cross-section of the one of the plurality of stems. In some implementations, the second channel is configured to surround at least half of said cross-section of the one of the plurality of stems. In some implementations, at least a portion of the first channel overlaps at least a portion of the second channel. In some implementations, the first channel overlaps less than an entirety of a cross-section of the second channel. In some implementations, overlapping portions of the first and second channels and non-overlapping portions of the first and second channels cooperate to define a generally rounded shape around the one of the plurality of stems. In some implementations, said generally rounded shape comprises an oblong shape.

[0018] In some implementations: the first channel comprises a web and legs extending from opposite ends of the web of the first channel; the second channel comprises a web and legs extending from opposite ends of the web of the second channel; and the legs of the first channel overlap the legs of the second channel when the first and second channels are positioned around the one of the plurality of stems. In some implementations, each of the webs of the first and second channels are generally planar. In some implementations, the legs of the first channel overlap only the legs of the second channel. In some implementations, said overlapping legs of the first and second channels and non-overlapping portions of the first and second channels cooperate to define a generally rounded shape around the one of the plurality of stems.

[0019] In some implementations: the one of the plurality of stems comprises a top portion, a bottom portion opposite the top portion, and opposing sides connecting the top and bottom portions; the sides of the one of the plurality of stems are positioned adjacent the legs of the second channel; and the overlapping legs of the first and second channels, the non-overlapping portions of the first and second channels, and the sides of the one of the plurality of stems cooperate to define said generally rounded shape around the one of the plurality of stems.

[0020] In some implementations, said generally rounded shape comprises an oblong shape. In some implementations: the legs of the second channel contact the sides of the one of the plurality of stems; and the sides of the one of the plurality of stems are configured such that outer surfaces of ends of the legs of the second channel are substantially flush with a plane of the top portion of the one of the plurality of stems. In some implementations: the legs of the second channel contact the sides of the one of the plurality of stems; and the sides of the one of the plurality of stems are configured such that there is a generally smooth transition between ends of the legs of the second channel and the top portion of the one of the plurality of stems. In some implementations, a gap between an outer surface of each of the legs of the second channel and a surface of the top portion of the one of the plurality of stems is less than 0.1 inch.

[0021] In some implementations: the first channel comprises a web and legs extending from opposite ends of the web of the first channel; the second channel comprises a web and legs extending from opposite ends of the web of the second channel; each of the legs of the first channel comprise a first end connected to the web of the first channel and a second end opposite the first end; and each of the legs of the first channel comprise a continuous curve between the first and second ends of each of the legs of the first channel. In some implementations: each of the legs of the second channel comprise a first end connected to the web of the second channel and a second end opposite the first end; and only a portion of each of the legs of the second channel comprises a continuous curve. In some implementations, the first channel comprises a generally C-shaped cross-section. In some implementations, the second channel member comprises a generally C-shaped cross-section.

[0022] In some implementations, the base further comprises: a first edge member extending along a first side of the base between the first and second ends; a second edge member extending along a second side of the base between the first and second ends; and a spine member extending

along at least a portion of the length and positioned between the first and second edge members. In some implementations, the plurality of openings comprises: a first plurality of openings spaced from one another along at least a portion of the length and extending between the first edge member and the spine member; and a second plurality of openings spaced from one another along at least a portion of the length and extending between the second edge member and the spine member. In some implementations, the plurality of stems comprises: a first plurality of stems, each of the first plurality of stems positioned between two of said first plurality of openings and extending between the first edge member and the spine member; and a second plurality of stems, each of the second plurality of stems positioned between two of said second plurality of openings and extending between the second edge member and the spine member. In some implementations, the first edge member, the second edge member, and the spine member are generally parallel to one another. In some implementations, the first edge member, the second edge member, and the spine member comprise an integrally molded structure.

[0023] In some implementations, a wearable device comprising a first strap and a second strap, each of the first and second straps comprising any of the straps described above, wherein: the spine member of the first strap comprises a plurality of spine member openings spaced apart from one another along a length of the spine member of the first strap, and wherein the plurality of spine member openings are configured to receive a tongue of a buckle coupled to the second strap thereby allowing a size of a closed loop formed by the first and second straps to be adjusted. In some implementations, a wearable device comprises any of the straps described above, wherein the wearable device is configured to secure to a wrist of the user and wherein the length of the base is configured to wrap around at least a portion of the user's wrist when in use. In some implementations, a wearable device comprises any of the straps described above, wherein the wearable device is configured to measure one or more physiological parameters of the user. In some implementations, the wearable device is configured to measure at least one of oxygen saturation and pulse rate of the user.

[0024] In some implementations, the plurality of strap members are configured to be removably secured to the portions of the base. In some implementations, the plurality of strap members are configured to be non-removably secured to the portions of the base. In some implementations, a wearable device comprises any of the straps described above, wherein the wearable device is a watch.

[0025] Disclosed herein is a method of manufacturing a strap for a wearable device, the method comprising: forming a base with a first material; and positioning a plurality of strap members around portions of the base along a length of the base, each of the plurality of strap members comprising a second material, wherein the first material of the base is more pliable than the second material of each of the plurality of strap members.

[0026] In some implementations, said forming said base with the first material comprises injection molding said base using a mold assembly. In some implementations, said mold assembly comprises a first mold portion and a second mold portion that are separable from one another. In some implementations, the first material comprises at least one of rubber and silicone. In some implementations, the second material

comprises metal. In some implementations, the second material comprises stainless steel. In some implementations, an amount of the strap that is comprised by the base is greater than an amount of the strap that is comprised by the plurality of strap members. In some implementations, the plurality of strap members do not comprise an integrally formed structure.

[0027] In some implementations, said forming said base with said first material comprises: forming the base with a first end, a second end, and sides separated by a width, wherein said length extends between said first and second ends; forming a plurality of openings in the base, said plurality of openings spaced from one another along the length of the base; and forming a plurality of stems in the base, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width. In some implementations, said positioning said plurality of strap members around said portions of the base along the length of the base comprises: positioning said plurality of strap members around the plurality of stems in the base. In some implementations, said plurality of strap members comprises a plurality of channels and wherein the method comprises securing said plurality of channels to the plurality of stems in the base. In some implementations, each of said plurality of channels comprises a web and at least one leg extending from the web, and wherein said securing said plurality of channels to the plurality of stems in the base comprises securing the web and at least one leg of each of the plurality of channels around a portion of one of the plurality of stems.

[0028] In some implementations, each of said plurality of channels comprises a web and two legs extending from the web, and wherein said securing the web and said at least one leg of each of the plurality of channels around the portion of the one of the plurality of stems comprises securing the web and the two legs around the portion of the one of the plurality of stems. In some implementations, said securing the web and the two legs around the portion of the one of the plurality of stems comprises securing the web and the two legs around less than an entirety of a cross-section of the one of the plurality of stems. In some implementations, said securing the web and the two legs around the portion of the one of the plurality of stems comprises securing the web and the two legs around an entirety of a cross-section of the one of the plurality of stems.

[0029] In some implementations, said plurality of channels comprises a plurality of pairs of channels, each of the plurality of pairs of channels comprising a first channel and a second channel, and wherein said securing said plurality of channels to the plurality of stems in the base comprises: securing the first channel around a first portion of one of the plurality of stems; and securing the second channel around a second portion of the one of the plurality of stems. In some implementations: said securing the first channel around said first portion of one of the plurality of stems comprises securing the first channel around less than an entirety of a cross-section of the one of the plurality of stems; and said securing the second channel around said second portion of the one of the plurality of stems comprises securing the second channel around less than the entirety of the cross-section of the one of the plurality of stems. In some implementations, said securing said first and second channels around said first and second portions of the one of the plurality of stems comprises securing the first and second

channels to the one of the plurality of stems such that the first and second channels cooperate to surround an entirety of a cross-section of the one of the one of the plurality of stems. In some implementations, said securing said first and second channels around said first and second portions of the one of the plurality of stems comprises overlapping portions of the first and second channels with each other.

[0030] In some implementations, each of the first and second channels comprises a web and opposing legs extending from the web, and wherein said overlapping portions of the first and second channels comprise said opposing legs of the first and second channels. In some implementations, said securing said first and second channels to said first and second portions of the one of the plurality of stems comprises securing said first and second channels such that overlapping portions of the first and second channels and non-overlapping portions of the first and second channels cooperate to define a generally rounded shape around the one of the plurality of stems. In some implementations, said generally rounded shape comprises an oblong shape.

[0031] In some implementations, said forming the said base further comprises: forming the base with a first edge member extending along a first side of the base between the first and second ends; forming the base with a second edge member extending along a second side of the base between the first and second ends; and forming the base with a spine member extending along at least a portion of the length and positioned between the first and second edge members. In some implementations, said forming said plurality of openings in the base comprises: forming a first plurality of openings spaced from one another along at least a portion of the length and between the first edge member and the spine member; and forming a second plurality of openings spaced from one another along at least a portion of the length and between the second edge member and the spine member.

[0032] In some implementations, said forming said plurality of stems in the base comprises: forming a first plurality of stems, each of the first plurality of stems positioned between two of said first plurality of openings and extending between the first edge member and the spine member; and forming a second plurality of stems, each of the second plurality of stems positioned between two of said second plurality of openings and extending between the second edge member and the spine member. In some implementations, the first edge member, the second edge member, and the spine member are formed generally parallel to one another. In some implementations, the first edge member, the second edge member, and the spine member are integrally molded. In some implementations, the method further comprises forming a plurality of spine member openings spaced apart from one another along a length of the spine member, wherein each of the plurality of spine member openings are configured to receive a tongue of a buckle coupled to a separate strap of the wearable device thereby allowing a size of a closed loop formed by the strap and the separate strap to be adjusted.

[0033] Disclosed herein is a strap for a wearable device configured to secure to a wrist of a user, the wearable device configured to measure one or more physiological parameters of the user. In some implementations, the strap comprises a base comprising an integral structure made of a first material, the base further comprising: a first end configured to connect to a portion of the wearable device; a second end opposite the first end; a length extending between the first

and second ends, wherein the base is configured to bend along the length to allow the strap to wrap around at least a portion of the user's wrist when in use; a width extending between opposite sides of the base; a plurality of openings spaced from one another along the length; and a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width. The strap can further comprise a plurality of pairs of channels positioned around the plurality of stems, each of the plurality of pairs of channels comprising: a first channel positioned partially around one of the plurality of stems such that the first channel surrounds less than an entirety of the one of the plurality of stems, wherein the first channel comprises a second material; and a second channel positioned partially around the one of the plurality of stems such that the second channel surrounds less than said entirety of the one of the plurality of stems, wherein the second channel comprises the second material. In some implementations, the first and second channels are secured to one another around the one of the plurality of stems such that portions of the first and second channels overlap one another. In some implementations, the second material of the first and second channels is less pliable than the first material of the base.

[0034] In some implementations, the first material comprises stainless steel. In some implementations, the second material comprises at least one of silicone and rubber. In some implementations: the first channel comprises a web and legs extending from opposite ends of the web of the first channel; the second channel comprises a web and legs extending from opposite ends of the web of the second channel; and the legs of the first channel overlap the legs of the second channel. In some implementations, the webs of the first and second channels do not overlap one another. In some implementations, the webs of the first and second channels are generally planar and wherein the legs of the first and second channels are curved. In some implementations, the legs of the first channel overlap only the legs of the second channel.

[0035] In some implementations: the one of the plurality of stems comprises a top portion, a bottom portion opposite the top portion, and opposing sides connecting the top and bottom portions; the sides of the one of the plurality of stems are positioned adjacent the legs of the second channel; and the overlapping legs of the first and second channels, non-overlapping portions of the first and second channels, and the sides of the one of the plurality of stems cooperate to define a generally rounded shape around the one of the plurality of stems. In some implementations: the legs of the second channel contact the sides of the one of the plurality of stems; and the sides of the one of the plurality of stems are configured such that at least a portion of an outer surface of each of the legs of the second channel is substantially flush with a plane of the top portion of the one of the plurality of stems.

[0036] In some implementations, the base further comprises: a first edge member at least partially defining a first side of the base between the first and second ends; a second edge member at least partially defining a second side of the base between the first and second ends, said second side being opposite said first side; and a spine member extending along at least a portion of the length and positioned between the first and second edge members, wherein the spine member is generally parallel to the first and second edge

members. In some implementations, the plurality of openings comprises: a first plurality of openings spaced from one another along at least a portion of the length and extending between the first edge member and the spine member; and a second plurality of openings spaced from one another along at least a portion of the length and extending between the second edge member and the spine member. In some implementations, the plurality of stems comprises: a first plurality of stems, each of the first plurality of stems positioned between two of said first plurality of openings and extending between the first edge member and the spine member; and a second plurality of stems, each of the second plurality of stems positioned between two of said second plurality of openings and extending between the second edge member and the spine member. In some implementations, a wearable device comprises any of the straps described above, wherein the wearable device is configured to measure at least one of oxygen saturation and pulse rate of the user.

[0037] Disclosed herein is a strap for a wearable device configured to secure to a wrist of a user. In some implementations, the strap comprises a base comprising an integral structure made of a first material, the base further comprising: a first end configured to connect to a portion of the wearable device; a second end opposite the first end; a length extending between the first and second ends; a width extending between opposite sides of the base; a plurality of openings spaced from one another along the length; and a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width. In some implementations, the strap further comprises a plurality of pairs of channels positioned around the plurality of stems, each of the plurality of pairs of channels comprising: a first channel positioned at least partially around one of the plurality of stems; and a second channel positioned at least partially around the one of the plurality of stems and secured to the first channel; wherein the first and second channels comprise a second material that is less pliable than the first material of the base.

[0038] In some implementations, the first material comprises a metallic material and wherein the second material comprises at least one of silicone and rubber. In some implementations, the first and second channels are not integral with one another. In some implementations: the first channel comprises a web and legs extending from opposite ends of the web of the first channel; the second channel comprises a web and legs extending from opposite ends of the web of the second channel; and the legs of the first channel overlap the legs of the second channel. In some implementations, the webs of the first and second channels do not overlap one another. In some implementations: the one of the plurality of stems comprises a top portion, a bottom portion opposite the top portion, and opposing sides connecting the top and bottom portions; the sides of the one of the plurality of stems contact the legs of the second channel; the legs of the second channel are sandwiched between the sides of the one of the plurality of stems and the legs of the first channel; and the overlapping legs of the first and second channels, non-overlapping portions of the first and second channels, and the sides of the one of the plurality of stems cooperate to define a generally rounded shape around the one of the plurality of stems.

[0039] Disclosed herein is a strap for a wearable device configured to secure to a portion of a user's body, the strap comprising: a base and a plurality of strap members secured to and/or positioned around portions of the base. In some implementations, the base comprises a first material and further comprises: a first end, a second end opposite the first end, and a length extending between the first and second ends; a plurality of openings spaced from one another along the length; and a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings. In some implementations, the plurality of strap members are positioned around the plurality of stems and comprise a second material that is less pliable than the first material.

[0040] In some implementations, the first material comprises a metallic material and the second material comprises at least one of silicone and rubber. In some implementations, the plurality of strap members comprises a plurality of pairs of channels positioned around the plurality of stems, each of the plurality of pairs of channels comprising: a first channel positioned partially around one of the plurality of stems such that the first channel surrounds less than an entirety of the one of the plurality of stems; and a second channel positioned partially around the one of the plurality of stems such that the second channel surrounds less than said entirety of the one of the plurality of stems. In some implementations, the first and second channels are secured to one another around the one of the plurality of stems such that portions of the first and second channels overlap one another.

[0041] Although various implementations of the straps disclosed herein may be described with reference to a wearable device that measures and/or monitors physiological parameters and/or characteristics of a wearer, any of the disclosed straps can be utilized with a wearable device that does not measure and/or monitor physiological parameters and/or characteristics of a wearer. For example, any of the straps disclosed herein may be utilized with a watch that does not measure and/or monitor physiological parameters and/or characteristics of a wearer. In such configurations, various implementations of the disclosed straps can advantageously provide increased comfort to the wearer, for example, via the incorporation of metal and pliable materials, such as metal channel members secured to a non-metallic (for example, silicone and/or rubber) body of the straps.

[0042] For purposes of summarizing the disclosure, certain aspects, advantages, and novel features are discussed herein. It is to be understood that not necessarily all such aspects, advantages, or features will be embodied in any particular embodiment of the disclosure, and an artisan would recognize from the disclosure herein a myriad of combinations of such aspects, advantages, or features.

BRIEF DESCRIPTION OF THE DRAWINGS

[0043] Certain features of this disclosure are described below with reference to the drawings. The illustrated embodiments are intended to illustrate, but not to limit, the embodiments. Various features of the different disclosed embodiments can be combined to form further embodiments, which are part of this disclosure.

[0044] FIGS. 1A-1B illustrate perspective views of a wearable device including straps in accordance with aspects of this disclosure.

[0045] FIG. 1C illustrates a perspective view of the wearable device and straps of FIGS. 1A-1B secured to a user's wrist in accordance with aspects of this disclosure.

[0046] FIG. 2 illustrates a schematic diagram illustrating certain features that can be incorporated into the wearable device of FIGS. 1A-1C in accordance with aspects of this disclosure.

[0047] FIGS. 3A-3B illustrate exploded perspective views of the wearable device of FIGS. 1A-1C in accordance with aspects of this disclosure.

[0048] FIG. 3C illustrates a top perspective view of a strap of the wearable device of FIGS. 1A-1C in accordance with aspects of this disclosure.

[0049] FIG. 3D illustrates a bottom perspective view of the strap of FIG. 3C in accordance with aspects of this disclosure.

[0050] FIG. 3E illustrates an exploded perspective view of the strap of FIG. 3C in accordance with aspects of this disclosure.

[0051] FIG. 3F illustrates an exploded side view of the strap of FIG. 3C in accordance with aspects of this disclosure.

[0052] FIG. 3G illustrates a perspective view of a cross-section taken through the strap of FIG. 3C in accordance with aspects of this disclosure.

[0053] FIG. 3H illustrates the perspective view of FIG. 3G with a portion of the strap of FIG. 3C removed in accordance with aspects of this disclosure.

[0054] FIG. 3I illustrates an enlarged perspective view of a portion of the strap shown in FIG. 3H in accordance with aspects of this disclosure.

[0055] FIGS. 3J-3K illustrate enlarged cross-sectional views of portions of the strap of FIG. 3C in accordance with aspects of this disclosure.

[0056] FIG. 4A illustrates a top perspective view of a strap in accordance with aspects of this disclosure.

[0057] FIG. 4B illustrates a bottom perspective view of the strap of FIG. 4A in accordance with aspects of this disclosure.

[0058] FIG. 4C illustrates an exploded perspective view of the strap of FIG. 4A in accordance with aspects of this disclosure.

[0059] FIG. 4D illustrates an exploded side view of the strap of FIG. 4A in accordance with aspects of this disclosure.

[0060] FIG. 4E illustrates a perspective view of a cross-section taken through the strap of FIG. 4A in accordance with aspects of this disclosure.

[0061] FIG. 4F illustrates an enlarged cross-sectional view of a portion of the strap of FIG. 4A in accordance with aspects of this disclosure.

[0062] FIG. 5A illustrates a top perspective view of a strap in accordance with aspects of this disclosure.

[0063] FIG. 5B illustrates a bottom perspective view of the strap of FIG. 5A in accordance with aspects of this disclosure.

[0064] FIG. 5C illustrates an exploded perspective view of the strap of FIG. 5A in accordance with aspects of this disclosure.

[0065] FIG. 5D illustrates an exploded side view of the strap of FIG. 5A in accordance with aspects of this disclosure.

[0066] FIG. 5E illustrates a perspective view of the strap of FIG. 5A in a partially assembled state in accordance with aspects of this disclosure.

[0067] FIG. 5F a perspective view of a cross-section taken through the strap of FIG. 5A in accordance with aspects of this disclosure.

[0068] FIGS. 5G-5H illustrate enlarged cross-sectional views of portions of the strap of FIG. 5A in accordance with aspects of this disclosure.

[0069] FIG. 6A illustrates a top perspective view of a strap in accordance with aspects of this disclosure.

[0070] FIG. 6B illustrates a bottom perspective view of the strap of FIG. 6A in accordance with aspects of this disclosure.

[0071] FIG. 6C a perspective view of a cross-section taken through the strap of FIG. 5A in accordance with aspects of this disclosure.

[0072] FIG. 6D illustrates an enlarged cross-sectional view of a portion of the strap of FIG. 6A in accordance with aspects of this disclosure.

[0073] FIGS. 6E-6L illustrate an exemplary method of manufacturing the strap of FIG. 6A in accordance with aspects of this disclosure.

DETAILED DESCRIPTION

[0074] Although certain embodiments and examples are described below, those of skill in the art will appreciate that the disclosure extends beyond the specifically disclosed embodiments and/or uses and obvious modifications and equivalents thereof based on the disclosure herein. Thus, it is intended that the scope of the disclosure herein disclosed should not be limited by any particular embodiments described below.

[0075] Daily use of a wearable health monitoring device can be beneficial to a wearer. Wearable devices which incorporate pulse oximetry components can be utilized to measure and/or monitor various physiological parameters and/or characteristics such as oxygen saturation (SpO_2), pulse rate, a plethysmograph waveform, perfusion index (PI), pleth variability index (PVI), methemoglobin (MetHb), carboxyhemoglobin (CoHb), total hemoglobin (tHb), glucose, electrocardiogram (ECG) parameters, among others.

[0076] FIGS. 1A-1B illustrate perspective views of a wearable device 1. The wearable device 1 can include one or more straps. For example, the wearable device 1 can include strap 100a and strap 100b. Straps 100a, 100b can be configured to secure to a portion of a user's body. For example, straps 100a, 100b can secure around a wrist of the user and/or can be secured to one another. While straps disclosed herein may be described and/or shown with reference to a wearer's wrist, any of the straps disclosed herein can be configured to secure to other portions of a wearer's body, such as an ankle, leg, arm, chest, among other locations.

[0077] FIG. 1C illustrates the wearable device 1 secured around a wrist 2 of a user. Wearable device 1 (for example, strap 100a and/or strap 100b) can include a mechanism configured to allow the straps 100a, 100b to secure around a portion of the user's body (for example, wrist 2). For example, with reference to FIGS. 1A-1B and 3A-3B, the wearable device 1 can include a buckle 190 that can facilitate securement of the straps 100a, 100b to one another. Buckle 190 can include a buckle body 192 and a tongue 194 (which can also be referred to as a "buckle tongue"). Straps 100a, 100b can be secured to one another via insertion of at

least a portion of strap 100a through an opening defined by buckle body 192 and insertion of tongue 194 through one of a plurality of openings in strap 100a (such as one of a plurality of openings 124 of strap 100b as shown in FIGS. 3C-3D and discussed further below). Buckle 190 can be coupled with an end of strap 100b. For example, buckle 190 can be coupled to an end of strap 100b via a pin that extends through a through-hole in an end of strap 100b and opposing holes in the buckle body 192. Such securement can rotatably couple the buckle body 192 to the end of the strap 100b. In some implementations, as shown in at least FIG. 1A, tongue 194 can be coupled (for example, rotatably coupled) to an end of strap 100b, for example, via the above-described pin that can extend through a through-hole in the end of strap 100b and at least partially through such opposing holes in buckle body 192. As shown, buckle body 192 can define an opening (for example, when coupled to an end of strap 100b) that can be configured to receive an end of strap 100a to facilitate securement of straps 100a, 100b and/or formation of a closed loop around a portion of the wearer's body.

[0078] Wearable device 1 can be a wristwatch incorporating a plethysmograph sensor (which may also be referred to as a "pulse oximeter" or "oximetry sensor" or "optical sensor") with built-in watch and/or time-indicating functions. Straps 100a, 100b can be pliable as described in more detail below which can allow tightness of the device 1 around the wrist 2 of the wearer be adjusted so as to provide better contact between the plethysmograph sensor and the wrist 2 while not compromising the comfort of the wearer and/or reducing the blood flow across the wrist 2 in a way that reduces the accuracy of physiological parameter measurement by the plethysmograph sensor. Accordingly, in some implementations, the wearable device 1 can eliminate the need to wear an additional sensor (for example, a pulse oximetry sensor) when going about daily activities. Incorporation of an oximetry sensor in wearable device 1 can provide the benefits of physiological information monitoring in a discrete (for example, hidden) form. A wearer of the wearable device 1 can be informed of physiological parameters, such as vital signs including but not limited to heart rate and oxygen saturation. This information can be helpful in providing feedback to the wearer and/or a third party user, for example, a healthcare professional or the wearer's family member, when the wearer is exercising, or otherwise for warning the wearer of possible health-related conditions, including but not limited to changes in the wearer's physiological parameters in response to medication that is being administered to the wearer.

[0079] FIG. 2 shows an illustrative schematic diagram of certain features that can be incorporated into wearable device 1. Wearable device 1 can include straps 100a, 100b and a module 10, which can be referred to as an electronic module or a watch module (for example, when the wearable device 1 is worn on a wrist like a wrist-watch). Watch module 10 can include strap connections 12a, 12b that can allow the straps 100a, 100b to couple to the watch module 10. Such strap connections 12a, 12b can be, for example, pin type connections between ends of straps 100a, 100b and the watch module 10. For example, strap connections 12a, 12b can comprise one or more holes in portions of the watch module 10 (for example, a body of the watch module 10) that receive ends of a pin, such as pin 403 shown in FIG. 6A) that can extend through holes in ends of straps 100a, 100b.

[0080] Watch module 10 can be similar or identical to any of those described in U.S. application Ser. No. 17/148,303, filed Jan. 13, 2021, and titled “Wearable Device with Physiological Parameters Monitoring”, which is incorporated by reference herein in its entirety. Watch module 10 can include a physiological parameter measurement module 30 configured to measure an indication of the wearer’s physiological parameters and/or characteristics, which can include, for example, pulse rate, respiration rate, SpO₂, Pleth Variability Index (PVI), Perfusion Index (PI), Respiration from the pleth (RRp), hydration, and/or other parameters and/or characteristics. The physiological parameter measurement module 30 can include a skin-interfacing cover that encloses one or more or a plurality of emitters 31a (such as LEDs) and one or more detectors 31b (such as photodiodes). Such cover can include a plurality of lenses separated by a plurality of light barriers, for example, as described in U.S. application Ser. No. 17/148,303.

[0081] In some implementations, watch module 10 includes a module processor 35 (which can include a memory) for driving the emitter(s) 31a to emit light of different wavelengths and/or to process one or more signals responsive to attenuated light after absorption by the body tissue of the wearer from the detectors 31b. Optionally, the module processor 35 can also determine and output for display the physiological parameters based on the detected signals. Alternatively, the module 10 can send the signals from the detectors 31b (for example, preprocessed signals) to a device processor 22, which can determine and output for display the physiological parameters based on the detected signals. The absorption of light can be via reflectance and/or transreflectance by the wearer’s body tissue, for example, by the pulsatile arterial blood flowing within a tissue site where the wearable device 1 is worn (for example, the wrist).

[0082] The emitter(s) 31a of the pulse oximeter module can be configured to emit a plurality of (for example, three, four, or more) wavelengths. The emitters 31a can be configured to emit light of a first wavelength providing an intensity signal that can act as a reference signal. The first wavelength can be more absorbent by the human body than light of other wavelengths emitted by the emitters 31a. The reference signal can be stronger and less likely to be affected by noise than the signals from other wavelengths emitted by the emitters 31a. The reference signal can be used by the module processor 35 to extract information from the other signals, for example, information relevant to and/or indicative of the pulsing rate, harmonics, or otherwise. The module processor 35 can focus the analysis on the extracted information for calculating physiological parameters of the wearer. The first wavelength can be from about 530 nm to about 650 nm, or from about 580 nm to about 585 nm, or from about 645 nm to about 650 nm, or about 580 nm, or about 645 nm. The light providing the reference signal can have an orange color. Alternatively, the light providing the reference signal can have a green color.

[0083] The emitters 31a can be configured to emit light having a second wavelength having a red color. The second wavelength can be from about 620 nm to about 660 nm. Light of the second wavelength can be more sensitive to changes in oxygen saturation (SpO₂). The second wavelength is preferably closer to 620 nm, which results in greater absorption by the body tissue of the wearer, and therefore a stronger signal and/or a steeper curve in the signal, than a wavelength that is closer to 660 nm. The

module processor 35 can extract information such as the pleth waveform from signals of the second wavelength.

[0084] The emitter(s) 31a can be configured to emit light having a third wavelength of about 900 nm to about 910 nm, or about 905 nm, or about 907 nm. The pulse oximeter processor can use the third wavelength as a normalizing wavelength when calculating ratios of the intensity signals of the other wavelengths.

[0085] Additionally or optionally, the emitters 31a can be configured to emit light having a fourth wavelength that is more sensitive to changes in water than the rest of the emitted wavelengths. The fourth wavelength can be about 970 nm. The module processor 35 can determine physiological parameters such as a hydration status of the wearer based at least in part on a comparison of the intensity signals of the fourth wavelength and a different wavelength detected by certain detectors 31b. The detectors 31b used for hydration monitoring, which will be described in greater detail below, can be located a predetermined distance away from the emitters 31a so that light travels through a certain depth of the tissue before being detected by those detectors 31b.

[0086] The watch module 10 can optionally include one or more thermistors 32 or other types of temperature sensors. The thermistor(s) 32 can be placed near one or more groups of emitters 31a. The thermistor(s) 32 can provide for wavelength correction of the light emitted by the emitters 31a. Optionally, the thermistor(s) 32 can additionally measure a temperature of the wearer of the wearable device 10. Optionally there can be one or more thermistors 32 located at other places of the watch module 10. The watch module 10 can include a gyroscope 36, an accelerometer 37, and/or other position and/or posture detection sensor(s). Optionally, the module processor 35, the gyroscope 36, and/or the accelerometer 37 can be located on a printed circuit board (PCB) 34 represented in FIG. 2 in dotted lines. The emitters 31a, the thermistor(s) 32, and/or the detectors 31b can also be positioned on the PCB 34 in some implementations.

[0087] As shown in FIG. 2, the watch module 10 can include its own device processor 22, which can be a digital/analog chip or other processor(s), such as a digital watch processor or a smartwatch processor. The watch module 10 can include a power source 24, which can be a battery, for powering the device processor 22, the display screen 20, and/or the pulse oximeter module 30. Optionally, the physiological parameter measurement module 30 can be preassembled before being integrated into the watch module 10. For example, a preassembled physiological parameter measurement module 30 can be secured within a device housing that includes two components releasably connected to each other using one or more screws or other fasteners. An electrical connection can be established between the pulse oximeter module PCB 34 and the circuit of the rest of the watch module 10, including for example, the device processor 22 and the display 20. Optionally, the electrical connection can include a flex circuit. The physiological parameter measurement module 30 can be characterized before being assembled with the rest of the watch module 10. Alternatively, a housing of the physiological parameter measurement module 30 can be an integral component of a housing of the watch module 10.

[0088] Optionally, as shown in FIG. 2, the watch module 10 can include an electrocardiogram (ECG) sensor including a plurality of electrodes 43, 45 configured to make contact with the wearer’s skin. One or more ECG electrodes 45 may

be located on and/or within the physiological parameter measurement module 30. One or more ECG electrodes 43 may be located elsewhere on the watch module 10 (for example, an ECG electrode 43 can form a part of a housing of the watch module 10. The ECG sensor can be in electrical communication with the module processor 35 via an ECG connector. Optionally, as shown in FIG. 2, the watch module 10 can include one or more other sensors 47, for example, one or more temperature sensors, a magnetometer, a moisture sensor, an impedance sensor, an acoustic sensor, among others.

[0089] With continued reference to FIG. 2, in some implementations, the watch module 10 includes a communication module 41. The communication module 41 can facilitate communication (via wires and/or wireless connection) between the watch module 10 (and/or components thereof) and separate devices, such as separate monitoring and/or mobile devices. For example, the communication module 41 can be configured to allow the watch module 10 to wirelessly communicate with other devices, systems, and/or networks over any of a variety of communication protocols. The communication module 41 can be configured to use any of a variety of wireless communication protocols, such as Wi-Fi (802.11x), Bluetooth®, ZigBee®, Z-wave®, cellular telephony, infrared, near-field communications (NFC), RFID, satellite transmission, proprietary protocols, combinations of the same, and the like. The communication module 41 can allow data and/or instructions to be transmitted and/or received to and/or from the watch module 10 and separate computing devices. The communication module 41 can be configured to transmit (for example, wirelessly) processed and/or unprocessed physiological or other information to a separate computing devices, which can include, among others, a mobile device (for example, an iOS or Android enabled smartphone, tablet, laptop), a desktop computer, a server or other computing or processing device for display and/or further processing, among other things. Such separate computing devices can be configured to store and/or further process the received physiological and/or other information, to display information indicative of or derived from the received information, and/or to transmit information—including displays, alarms, alerts, and notifications—to various other types of computing devices and/or systems that may be associated with a hospital, a caregiver (for example, a primary care provider), and/or a user (for example, an employer, a school, friends, family) that have permission to access the subject's data. As another example, the communication module 41 can be configured to wirelessly transmit processed and/or unprocessed obtained physiological information and/or other information (for example, motion and/or location data) to a mobile phone which can include one or more hardware processors configured to execute an application that generates a graphical user interface displaying information representative of the processed or unprocessed physiological and/or other information. The communication module 41 can be and/or include a wireless transceiver.

[0090] In some implementations, the watch module 10 includes a strain gauge 26 that can be utilized to measure a pressure of the watch module 10 and/or wearable device 1 on the wearer. Strain gauge 26 can be similar or identical to that described in U.S. application Ser. No. 17/148,303.

[0091] FIGS. 3A-3B illustrate exploded perspective views of the wearable device 1 of FIGS. 1A-1C. As shown, the

wearable device 1 can include strap 100a, strap 100b, watch module 10, and a buckle 190 that can include a buckle body 192 and tongue 194 as discussed above. Strap 100a and/or strap 100b can comprise more than one material. For example, strap 100a and/or strap 100b can comprise at least two materials. Strap 100a and/or strap 100b can comprise two materials with different material properties. For example, strap 100a and/or strap 100b can comprise two materials where one of the two materials is more pliable (for example, more stretchable) than the other.

[0092] With reference to FIGS. 3A-3B, strap 100a can comprise a base 110a (which may also be referred to as a “main body”) and/or strap 100b can comprise a base 110b (which may also be referred to as a “main body”). In some implementations, base 110a and/or base 110b comprise a pliable (for example, stretchable) material. In some implementations, base 110a and/or base 110b only comprises one material, and such material can be pliable (for example, stretchable). For example, base 110a and/or base 110b can comprise an elastomeric material, such as rubber and/or silicone. In some implementations, base 110a and/or base 110b does not comprise a metallic material.

[0093] Each of strap 100a and/or strap 100b can include one or more or a plurality of strap members secured to portions of the base 110a, 110b along a length of the base 110a, 110b. Such strap members can be secured at various locations of the base 110a, 110b. For example, such strap members can be secured and/or operably positioned by the base 110a, 110b so as to contact skin of a wearer when the strap 100a and/or strap 100b is in use (for example, where the wearable device 1 is secured to a portion of the wearer's body). In some implementations, such strap members are secured to interior portions of the base 110a, 110b, for example, portions of the base 110a, 110b that are spaced away from edges and/or ends of the base 110a, 110b. Such strap members can comprise a material that is less pliable (for example, less stretchable) than a material that the base 110a, 110b is made of. For example, such strap members can comprise a metallic material, such as stainless steel. In some implementations, such strap members do not comprise an elastomeric material. In some implementations, such strap members do not comprise rubber and/or do not comprise silicone. In some implementations, such strap members do not comprise leather and/or do not comprise a fabric material. Such strap members can be non-integrally formed with one another (for example, separate from one another) and/or non-integrally formed with the base 110a, 110b. In some implementations, such strap members limit an ability of the base 110a, 110b to stretch, for example, along a width and/or length of the base 110a, 110b and/or along a direction of an axis that is parallel to the width and/or length of the base 110a, 110b. In some implementations, such strap members are smooth, thereby aiding user comfort when the strap 100a, 100b is in use and such strap members contact skin of the wearer. Such strap members can be, for example, channels 150, 152 which are discussed further below.

[0094] With continued reference to FIGS. 3A-3B, each of strap 100a and 100b can include one or more or a plurality of channels 150, 152. Channels 150, 152 can secure to portions of the base 110a, 110b, for example, as discussed further below. FIGS. 3A-3B illustrate exemplary amounts of channels 150, 152 and/or how channels 150, 152 can be arranged in rows and columns when secured to and/or operably positioned by the base 110a, 110b. The number

and/or arrangement of channels 150, 152 can vary, for example, depending on characteristics of the strap 100a, 100b. For example, the number and/or arrangement of channels 150, 152 can vary depending on the length and/or width of the strap 100a, 100b, which can itself vary depending on an intended size of the strap (for example, small, medium, large, etc.) based on the wearer. Accordingly, illustrated number and/or arrangement of the channels 150, 152 is not intended to be limiting.

[0095] Channels 150, 152 can comprise a metallic material, such as stainless steel. In some implementations, channels 150, 152 only comprise a metallic material. In some implementations, channels 150, 152 do not comprise an elastomeric material. For example, in some implementations, channels 150, 152 do not comprise rubber and/or do not comprise silicone. In some implementations, channels 150, 152 do not comprise leather and/or do not comprise fabric.

[0096] With continued reference to FIGS. 3A-3B, an end of strap 100a can be secured to a portion of watch module 10 and/or an end of strap 100b can be secured to a portion of watch module 10. For example, an end of strap 100a can be secured to a portion of watch module 10 via a pin (for example, pin 403 shown in FIG. 6A) that can extend through an opening (for example, a through-hole such as hole 129 shown in FIG. 3C) at an end of base 110a which can secure to a portion of the watch module 10. Additionally or alternatively, an end of strap 100b can be secured to a portion of watch module 10 via a pin that can extend through an opening (for example, a through-hole) at an end of base 110b which can secure to a portion of the watch module 10. Such securement can allow the strap 100a, 100b (for example, base 110a, 110b) to rotate relative to watch module 10 and/or portions thereof which can allow the straps 100a, 100b to wrap around a portion of the wearer's body in some implementations.

[0097] FIGS. 3C-3K illustrate various portions of strap 100a. Any or all of the features of strap 100a discussed below can be applicable to strap 100b. For example, strap 100b can include channels 150, 152 discussed below with reference to strap 100a. In some implementations, strap 100b includes a different amount (for example, less) of the channels 150, 152 than does strap 100a, for example, where strap 100a is longer than strap 100b. As discussed above, strap 100b can be coupled with buckle 190, and in some implementations where strap 100b is coupled with buckle 190, strap 100b is shorter than strap 100a. In some implementations as can be seen in FIGS. 3A-3B, "free" ends of straps 100a, 100b (for example, ends which are not connected to watch module 10) are different from one another, such as where strap 100b is coupled with buckle 190 and where strap 100a include a tip 126 that can pass through the buckle 190 to facilitate size adjustment of the wearable device 1.

[0098] FIG. 3C illustrates a top perspective view of strap 100a and FIG. 3D illustrates a bottom perspective view of strap 100a. Strap 100a can include a first end 112, a second end 114 opposite the first end 112, a length extending between the ends 112, 114, and a width extending between sides of the strap 100a. Such ends 112, 114, length, width, and sides can be defined by the base 110a of the strap 100a.

[0099] FIG. 3E illustrates an exploded perspective view of strap 100a and FIG. 3F illustrates an exploded side view of strap 100a. FIG. 3G illustrates a cross-section taken through

the strap 100a as shown in FIG. 3C, while FIG. 3H illustrates the strap 100a shown in FIG. 3G with channels 150, 152 removed so as to better illustrate portions of the base 110a which are described below. FIG. 3E illustrate exploded top and side perspective views of the strap 110a with channels 150, 152 spaced from (for example, disassembled from) base 110a.

[0100] With reference to at least FIGS. 3C-3D and 3E, base 110a can include first end 112, second end 114, and edge members 116, 118 that can extend between ends 112, 114 at and/or along sides of base 110a. Edge members 116, 118 can define the sides of the base 110a. As discussed previously, strap 100a can be configured to couple with a portion of watch module 10. Base 110a can include a coupling mechanism that can allow base 110a (and therefore strap 100a) to couple (for example, removably couple) to a portion of the watch module 10. For example, in some implementations, a portion of the base 110a is configured to receive a pin which can itself secure to a portion of the watch module 10. For example, the base 110a can include a coupling portion 128 that includes an opening 129 extending through at least a portion of the coupling portion 128, which is configured to receive a pin (such as pin 403 as shown in FIG. 6A) configured to secure to a portion of the watch module 10. Coupling portion 128 can extend at and/or along end 112 of the base 110a. Coupling portion 128 can extend along a portion (for example, an entirety) of a width of the base 110a. Opening 129 can extend along all or a portion of coupling portion 128. In some implementations, coupling portion 128 is rounded (for example, comprises an at least partially circular cross-section) and/or opening 129 comprises a circular cross-section. Coupling portion 128 can be connected to edge member 116, edge member 118, and/or spine member 120 (discussed further below).

[0101] In some implementations, base 110a includes a tip 126 at end 114, which can be opposite end 112 where the coupling portion 128 is located. Tip 126 can be configured to be inserted through an opening defined by buckle body 192, for example, when buckle body 192 is coupled to an end of strap 110b as described above. Tip 126 can be connected to edge member 116, edge member 118, and/or spine member 120.

[0102] In some implementations, base 110a includes one or more and/or a plurality of openings along a length and/or width, between ends 112, 114 and/or sides of the base 110a. For example, base 110a can include one, two, three, four, five, six, seven, eight, nine, ten, eleven, twelve, thirteen, fourteen, fifteen, sixteen, seventeen, eighteen, nineteen, or twenty or more openings. As another example, base 110a can include between one and a hundred openings, between ten and ninety openings, between twenty and eighty openings, between thirty and seventy openings, between forty and sixty openings, between ten and fifty openings, or between twenty and thirty openings, or any number of openings between any of these ranges, or any range bounded by any combination of values within these ranges. For example, with reference to FIG. 3H (which shows a cross-section taken through base 110a), base 110a can include one or more openings 122. Openings 122 can be spaced apart from one another along a length of the base 110a between ends 112, 114. For clarity, only some of the openings 122 are labeled in FIGS. 3C-3D and FIGS. 3G-3H. Base 110a can include one or more or a plurality of stems 130 that are positioned between and/or defined by (for example, defined

at least partially by) openings 122. For example, base 110a can include one, two, three, four, five, six, seven, eight, nine, ten, eleven, twelve, thirteen, fourteen, fifteen, sixteen, seventeen, eighteen, nineteen, or twenty or more stems 130, and/or between one and a hundred, between ten and ninety, between twenty and eighty, between thirty and seventy, between forty and sixty, between ten and fifty, or between twenty and thirty stems 130, or any number of stems 130 between any of these ranges, or any range bounded by any combination of values within these ranges. Each of stems 130 can be spaced apart from one another by the openings 122. Each of the stems 130 can be positioned between two of the openings 122, for example, as shown. Advantageously, openings 122 can provide greater comfort to the wearer of a wearable device 1 including strap 110a by increasing breathability. Additionally, in some implementations, openings 122 can provide greater flexibility to band 110a, allowing band 110a to better wrap around a portion of the wearer's body.

[0103] In some implementations, base 110a includes a spine member 120. Spine member 120 can extend along the length of the base 110a and/or a portion of such length between ends 112, 114. For example, in some implementations of base 110a, spine member 120 extends between coupling portion 128 and tip 126. Spine member 120 can extend along an interior of base 110a. Spine member 120 can be spaced from (for example, inset from) edge member 116 and/or edge member 118. In some implementations, spine member 120 is parallel to edge member 116 and/or edge member 118. Spine member 120 can be separated from edge members 116, 118 by stems 130, for example, where stems 130 extend between edge members 116, 118 and spine member 120. In some implementations, stems 130 are transverse (for example, perpendicular) to edge member 116, edge member 118, and/or spine member 120.

[0104] Spine member 120 can include one or more or a plurality of openings 124 configured to facilitate securement of strap 100a to strap 100b. For clarity, only one of such openings 124 is labeled in FIGS. 3C-3D and 3G-3H. Spine member 120 can include one, two, three, four, five, six, seven, eight, nine, ten, eleven, twelve, thirteen, fourteen, fifteen, sixteen, seventeen, eighteen, nineteen, or twenty or more openings 124, and/or between one and a hundred, between ten and ninety, between twenty and eighty, between thirty and seventy, between forty and sixty, between ten and fifty, or between twenty and thirty openings 124, or any number of openings 124 between any of these ranges, or any range bounded by any combination of values within these ranges. Openings 124 can be sized and/or shaped to receive tongue 194 of buckle 190 to be positioned therethrough, thus allowing straps 100a, 100b to form a closed loop around a portion of a wearer's body (for example, wrist, arm, ankle, etc.). Inclusion of a plurality of openings 124 in spine member 120 can allow a size of such closed loop to be adjusted.

[0105] The number of stems 130 and/or openings 122 can vary and/or stems 130 and/or openings 122 can be arranged in one or more or a plurality of rows and one or more or a plurality of columns. For example, as shown in at least FIG. 3E, band 110a can include a plurality of stems 130 arranged in two columns and a plurality of rows. While FIG. 3E illustrates band 110a with a plurality of stems 130 arranged in two columns and twelve rows, the band 110a can include a different number and/or arrangement of stems 130. In

some implementations such as that illustrated in the figures, band 110a can include two columns of stems 130 separated by spine member 120.

[0106] In some implementations, portions of the band 110a are configured to facilitate bending and/or flexing around a portion of the wearer's body when in use (for example, when the strap 100a is forming a closed loop around the portion of the wearer's body). For example, in some implementations, the edge member 116, edge member 118, and/or spine member 120 include one or more or a plurality of living hinges that facilitate bending of the band 110a. With reference to FIG. 3E, such living hinges can be defined by narrowing portions 116a, 118a, 120a in each of edge member 116, edge member 118, and spine member 120 (respectively). Edge member 116, edge member 118, and spine member 120 can include one, two, three, four, five, six, seven, eight, nine, ten, eleven, twelve, thirteen, fourteen, fifteen, sixteen, seventeen, eighteen, nineteen, or twenty or more of narrowing portions 116a, 118a, 120a, and/or between one and a hundred, between ten and ninety, between twenty and eighty, between thirty and seventy, between forty and sixty, between ten and fifty, or between twenty and thirty of narrowing portions 116a, 118a, 120a, or any number of narrowing portions 116a, 118a, 120a between any of these ranges, or any range bounded by any combination of values within these ranges. In some implementations, the number of narrowing portions 116a, 118a, 120a in edge member 116, edge member 118, and spine member 120 (respectively) corresponds to the number of openings 122 in band 110a. Narrowing portions 116a, 118a, 120a can be defined by a reduction in cross-sectional area along the edge member 116, edge member 118, and spine member 120. For example, narrowing portions 116a, 118a, 120a can be defined by a reduction in cross-sectional area caused by a varying height (which may also be referred to as "thickness") along the edge member 116, edge member 118, and spine member 120 (respectively). In some implementations, band 110a includes a plurality of triads of narrowing portions 116a, 118a, 120a, where each triad includes a narrowing portion 116a, a narrowing portion 118a, and a narrowing portion 120a. In some implementations, each of such triads are aligned with one another and/or aligned with one of openings 122.

[0107] As mentioned previously, FIGS. 3E and 3F illustrate top and side exploded perspective views of strap 100a. FIGS. 3E-3F also illustrate channels 150, 152 detached from band 110a and FIG. 3G illustrates channels 150, 152 secured to band 110a (for example, secured to stems 130). FIG. 3I illustrates an enlarged view of a portion of the band 110a shown in FIG. 3H. More specifically, FIG. 3I illustrates an enlarged view of one of the stems 130 adjacent two openings 122. FIG. 3J shows an enlarged side view of a channel 150 and a channel 152 spaced from a stem 130 (for example, disassembled from stem 130), while FIG. 3K illustrates an enlarged side view of the channels 150, 152 secured to the stem 130.

[0108] Channel 150 can be sized and/or shaped to secure to and/or surround stem 130 or a portion thereof. In some implementations, channel 150 is configured to surround a portion of stem 130. In some implementations, channel 150 is configured to surround less than an entirety of a cross-section of stem 130. Channel 150 can include a web 150a and one or more legs extending from web 150a. For example, channel 150 can include one or both of legs 150b,

150c that can extend from web **150a**. Legs **150b**, **150c** can extend transverse (for example, perpendicular to) web **150a**. Legs **150b**, **150c** can extend from ends of web **150a**, for example, opposing ends of web **150a**. In some implementations, legs **150b**, **150c** are curved, for example, along all or a portion of lengths of legs **150b**, **150c**. In some implementations, legs **150b**, **150c** extend from web **150a** and are curved toward each other. In some implementations, legs **150b**, **150c** are curved along an entirety of their lengths. In some implementations, web **150a** comprises a greater length than one or both of legs **150b**, **150c**. Alternatively, in some implementations, web **150a** has an equal or smaller length than one or both of legs **150b**, **150c**. In some implementations, web **150a** is substantially planar. In some implementations, web **150a** is not curved. In some implementations, channel **150** is C-shaped.

[0109] Channel **152** can be sized and/or shaped to secure to and/or surround stem **130** or a portion thereof. In some implementations, channel **152** is configured to surround a portion of stem **130**. In some implementations, channel **152** is configured to surround less than an entirety of a cross-section of stem **130**. Channel **152** can include a web **152a** and one or more legs extending from web **152a**. For example, channel **152** can include one or both of legs **152b**, **152c** that can extend from web **152a**. Legs **152b**, **152c** can extend transverse (for example, perpendicular to) web **152a**. Legs **152b**, **152c** can extend from ends of web **152a**, for example, opposing ends of web **152a**. In some implementations, legs **152b**, **152c** are curved, for example, along all or a portion of lengths of legs **152b**, **152c**. In some implementations, legs **152b**, **152c** extend from web **152a** and are curved toward each other. In some implementations, legs **152b**, **152c** comprise notches **152d**, **152e** at and/or near where legs **152b**, **152c** connect to web **152a**. Notches **152d**, **152e** can be sized and/or shaped to be accommodated by portions of sides **130c**, **130d** of stem **130** as discussed in more detail below. In some implementations, legs **152b**, **152c** are sized and/or shaped to be accommodated by sides **130c**, **130d** of stem **130** such that outer portions (for example, outer surfaces) of legs **152b**, **152c** form a rounded shape when positioned adjacent a top portion **130a** of stem **130** as explained in more detail below. In some implementations, legs **152b**, **152c** comprise a continuous curve along only a portion of their lengths. For example, in some implementations where legs **152b**, **152c** comprise notches **152d**, **152e**, legs **152b**, **152c** comprise a continuous curve from the notches **152d**, **152e** to a free end of the legs **152b**, **152c**. In some implementations, web **152a** comprises a greater length than one or both of legs **152b**, **152c**. Alternatively, in some implementations, web **152a** has an equal or smaller length than one or both of legs **152b**, **152c**. In some implementations, web **152a** is substantially planar. In some implementations, web **152a** is not curved. In some implementations, channel **152** is C-shaped.

[0110] With reference to FIG. 3J, stem **130** can include a top portion **130a**, a bottom portion **130b** opposite the top portion **130a**, and sides **130c**, **130d**. Bottom portion **130b** can face toward skin of the wearer and/or be positioned closer to skin of the wearer than top portion **130a** when the strap **100a** is in use, for example, with a wearable device **1** when secured to the wearer. Top portion **130a** can face away from skin of the wearer and/or be positioned farther from skin of the wearer than bottom portion **130b** when the strap **100a** is in use. With reference to FIGS. 3J-3K, sides **130c**,

130d can be configured to accommodate a size and/or shape of legs **152b**, **152c** of channel **152** such that, when channel **152** is secured to stem **130** and legs **152b**, **152c** are positioned adjacent to and/or contact sides **130c**, **130d**, free ends of legs **152b**, **152c** and top portion **130a** cooperate to form a generally smooth transition. For example, an outer surface of legs **152b**, **152c** at free ends of legs **152b**, **152c** can be substantially flush with an outer surface of top portion **130a**. A gap between the top portion **130a** and free ends of legs **152b**, **152c** can be less than approximately 0.2 inch, less than approximately 0.1 inch, less than approximately 0.05 inch, less than approximately 0.01 inch, or less than approximately 0.005 inch, for example, in some implementations.

[0111] In some implementations, legs **152b**, **152c** of channel **152** are configured to accommodate and/or secured adjacent to legs **150b**, **150c** of channel **150** (for example, when secured to and/or around stem **130**) such that channel **150** and channel **152** cooperate to form a generally rounded shape. In some implementations, notches **152d**, **152e** are configured to allow free ends of legs **150b**, **150c** of channel **150** to meet web **152a** of channel **152** and form a generally smooth transition. In some implementations, an outer surface of legs **150b**, **150c** at free ends of legs **150b**, **150c** is substantially flush with an outer surface of web **152a**. A gap between the top web **152a** and free ends of legs **150b**, **150c** can be less than approximately 0.2 inch, less than approximately 0.1 inch, less than approximately 0.05 inch, less than approximately 0.01 inch, or less than approximately 0.005 inch, for example, in some implementations. With continued reference to FIG. 3K, in some implementations, when channels **150**, **152** secure to stem **130** (and/or to one another), channels **150**, **152** and/or stem **130** can form a generally rounded shape, for example, an oblong shape.

[0112] Channel **150** and/or channel **152** can surround less than an entirety of stem **130** when secured thereto and/or when secured to one another. In some implementations, channel **150** and/or channel **152** surrounds less than approximately 90%, less than approximately 80%, less than approximately 70%, or less than approximately 60% of a perimeter of a cross-section of stem **130** when secured to stem **130**. Additionally or alternatively, in some implementations, channel **150** and/or channel **152** surrounds at least approximately 10%, at least approximately 20%, at least approximately 30%, at least approximately 40%, at least approximately 50%, at least approximately 60%, at least approximately 70%, or at least approximately 80% of a perimeter of a cross-section of stem **130** when secured to stem **130**.

[0113] When channels **150**, **152** are secured to stem **130** and/or each other, portions of channels **150**, **152** can overlap one another. For example, in some implementations, when channels **150**, **152** are secured to stem **130**, portions of channel **150** overlap portions of channel **152**. As another example, in some implementations, when channels **150**, **152** are secured to stem **130**, one or both of legs **150b**, **150c** of channel **150** overlap one or both of legs **152b**, **152c** of channel **152**. In some implementations, only the legs **150b**, **150c** of channel **150** overlap portions of channel **152** (for example, legs **152b**, **152c**). In some implementations, legs **152b**, **152c** are sandwiched between sides **130c**, **130d** of stem **130** and legs **150b**, **150c** when channels **150**, **152** are secured to stem **130**. In some implementations, overlapping portions of channels **150**, **152** (for example, legs **150b**, **150c**, **152b**, **152c**) and non-overlapping portions of channels **150**,

152 (for example, webs **150a**, **152a**) form a generally rounded shape when secured to one another and/or around stem **130**. Such generally rounded shape can be, for example, an oblong shape. In some implementations, stem **130**, channel **150**, and channel **152** cooperate to form a generally rounded shape (for example, an oblong shape) when secured to one another. For example, in some implementations, sides **130c**, **130d**, overlapping portions of channels **150**, **152** (for example, legs **150b**, **150c**, **152b**, **152c**) and non-overlapping portions of channels **150**, **152** (for example, webs **150a**, **152a**) form a generally rounded shape when channel **150**, channel **152**, and stem **130** are secured to one another.

[0114] With continued reference to FIG. 3J, in some implementations, stems **130** have a height h_1 that is smaller than a height h_2 of the spine member **120**. Heights h_1 and h_2 can be orthogonal to a length of the strap **100a** extending between ends **112**, **114** of the strap **100a** (see, for example, FIG. 3C) and/or heights h_1 and h_2 can be orthogonal to a width of the strap **100a** (and/or base **110a**) extending from sides of the strap **100a** (which can be defined by edge members **116**, **118**). Heights h_1 and h_2 can be also be referred to as thicknesses of stems **130** and spine member **120**, respectively. As shown in FIG. 3J and as discussed previously, spine member **120** can include narrowing portions **120a** which can be defined by a height h_3 . Height h_3 can be smaller than height h_2 . Height h_3 can be greater than or equal to height h_1 .

[0115] Strap **100a** can be manufactured and/or assembled in a variety of ways. In some implementations, band **110a** is formed via a molding (for example, injection molding) process. For example, ends **112**, **114**, edge members **116**, **118**, spine member **120**, stems **130**, tip **126**, and/or coupling portion **128** can be formed via injection molding of a material, for example, an elastomeric material. Such elastomeric material can comprise silicone and/or rubber, for example. Such molding process can be utilized to form openings **124**, openings **122**, and/or opening **129**, all of which are discussed elsewhere herein. Channels **150**, **152** can be formed of a metallic material (for example, via an extrusion process). As discussed previously, channels **150**, **152** can comprise stainless steel. In some implementations, channels **150**, **152** only comprise a metallic material. In some implementations, the number of channels **150** and channels **152** corresponds to the number of stems **130** in base **110a**. After the channels **150**, **152** are formed, channels **150**, **152** can be secured to stems **130** of base **110**, for example, as shown in FIGS. 3G and 3K. For example, channel **152** can be secured around at least a portion of stem **130**, and, thereafter, channel **150** can be secured around at least a portion of stem **130** and at least a portion of channel **152**. In some implementations, channel **150** and/or channel **152** can be snapped into engagement around stem **130** and/or with each other. In some implementations, channels **150**, **152** are configured and/or are secured to stem **130** so as to be removably attachable by a user (for example, a wearer of a wearable device **1** including strap **100a**). Alternatively, in some implementations, channels **150**, **152** are configured and/or are secured to stem **130** so as to be not removably attachable by a user (for example, a wearer of a wearable device **1** including strap **100a**).

[0116] FIGS. 4A-4F illustrate a strap **200a**. Strap **200a** can be utilized with wearable device **1** and/or watch module **10** in a similar or identical manner as that described elsewhere

herein with reference to strap **100a**. Further, wearable device **1** can include two straps that include some, many, or all of the features described below with respect to strap **200a**, for example, so that the wearable device **1** can be secured around a portion of a wearer's body with two straps **200a**. Strap **200a** can be similar or identical to strap **100a** in some or many respects. With reference to at least FIGS. 4A-4B, strap **200a** can include a base **210a** (which may also be referred to as a "main body"), an end **212**, end **214**, a length extending between ends **212**, **214**, sides which can include and/or be defined by edge members **216**, **218**, a tip **226** at or near end **214**, and/or a coupling portion **228** including an opening **229** at or near end **212**. End **212**, end **214**, edge members **216**, **218**, tip **226**, coupling portion **228**, and/or opening **229** can be similar or identical to end **112**, end **114**, edge members **116**, **118**, tip **126**, coupling portion **128**, and/or opening **129** described above with reference to strap **100a**. Similar to strap **100a**, strap **200a** can comprise more than one material. For example, strap **200a** can comprise at least two materials. Strap **200a** can comprise two materials with different material properties. For example, strap **200a** can comprise two materials where one of the two materials is more pliable (for example, more stretchable) than the other. In some implementations, base **210a** comprise a pliable (for example, stretchable) material. In some implementations, base **210a** only comprises one material, and such material can be pliable (for example, stretchable). For example, base **210a** can comprise an elastomeric material, such as rubber and/or silicone. In some implementations, base **210a** does not comprise a metallic material.

[0117] Similar to strap **100a**, strap **200a** can include one or more or a plurality of strap members secured to portions of the base **210a** along a length of the base **210a** and which can be secured at various locations of the base **210a**. Such strap members can comprise a material that is less pliable (for example, less stretchable) than a material that the base **210a** is made of. For example, such strap members can comprise a metallic material, such as stainless steel. In some implementations, such strap members do not comprise an elastomeric material. In some implementations, such strap members do not comprise rubber and/or do not comprise silicone. In some implementations, such strap members do not comprise leather and/or do not comprise a fabric material. Such strap members can be non-integrally formed with one another (for example, separate from one another) and/or non-integrally formed with the base **210a**. In some implementations, such strap members limit an ability of the base **210a** to stretch, for example, along a width and/or length of the base **210a** and/or along a direction of an axis that is parallel to the width and/or length of the base **210a**. Such strap members can be, for example, channels **250**. Strap **200a** can include one or more or a plurality of channels **250**.

[0118] FIGS. 4C-4D illustrate exemplary amounts of channels **250** and/or how channels **250** can be arranged in rows and columns when secured to and/or operably positioned by the base **210a**. The number and/or arrangement of channels **250** can vary, for example, depending on characteristics of the strap **200a**. For example, the number and/or arrangement of channels **250** can vary depending on the length and/or width of the strap **200a**, which can itself vary depending on an intended size of the strap (for example, small, medium, large, etc.) based on the wearer. Accordingly, illustrated number and/or arrangement of the channels **250** is not intended to be limiting. Channels **250** can

comprise a metallic material, such as stainless steel. In some implementations, channels 250 only comprise a metallic material. In some implementations, channels 250 do not comprise an elastomeric material. For example, in some implementations, channels 250 do not comprise rubber and/or do not comprise silicone. In some implementations, channels 250 do not comprise leather and/or do not comprise fabric.

[0119] Base 210a can include one or more and/or a plurality of openings 222 along a length and/or width, between ends 212, 214 and/or sides of the base 210a. With reference to FIG. 4B, the number and/or arrangement of openings 222 can vary and/or the number of openings 222 can be equal to the values discussed above with reference to base 110a, for example. Openings 222 can be spaced apart from one another along a length of the base 210a between ends 212, 214. For clarity, only some of the openings 222 are labeled in FIGS. 4A-4C. Base 210a can include one or more or a plurality of stems 230 that are positioned between and/or defined by (for example, defined at least partially by) openings 222. The number and/or arrangement of stems 230 can vary and the number of stems 230 can be equal to the values discussed above with reference to base 110a, for example. Each of stems 230 can be spaced apart from one another by the openings 222. Each of the stems 230 can be positioned between two of the openings 222, for example, as shown. Openings 222 can provide benefits similar or identical to those discussed above with respect to openings 122.

[0120] Base 210a can include a spine member 220 which may be similar or identical to spine member 120 in some or many respects. Spine member 220 can extend along the length of the base 210a and/or a portion of such length between ends 212, 214. For example, in some implementations of base 210a, spine member 220 extends between coupling portion 228 and tip 226. Spine member 220 can extend along an interior of base 210a. Spine member 220 can be spaced from (for example, inset from) edge member 216 and/or edge member 218. In some implementations, spine member 220 is parallel to edge member 216 and/or edge member 218. Spine member 220 can be separated from edge members 216, 218 by stems 230, for example, where stems 230 extend between edge members 216, 218 and spine member 220. In some implementations, stems 230 are transverse (for example, perpendicular) to edge member 216, edge member 218, and/or spine member 220. Spine member 220 can include one or more or a plurality of openings 224 which can be similar or identical to openings 124 described above with reference to spine member 120. For clarity, only some of the openings 124 are labeled in FIGS. 4A-4C. The number and/or arrangement of openings 224 can vary and the number of openings 224 can be equal to the values discussed above with reference to spine member 120, for example.

[0121] The number of stems 230 and/or openings 222 can vary, and stems 130 and openings 222 can be arranged in one or more or a plurality of rows and one or more or a plurality of columns, for example, similar to as discussed with reference to stems 130 and openings 122 above. With reference to FIG. 4B, in some implementations, bottom surfaces of stems 230 and spine member 220 extend and/or are defined along a common plane or surface which defines a bottom surface of base 210a.

[0122] Band 210a (and/or portions thereof) can be configured to facilitate bending and/or flexing around a portion

of the wearer's body when in use in a similar or identical manner as that discussed above with reference to band 110a. For example, edge member 216, edge member 218, and/or spine member 220 can include one or more or a plurality of living hinges that facilitate bending of the band 210a. Such living hinges can be defined by narrowing portions 216a, 218a, 220a in each of edge member 216, edge member 218, and spine member 220 (respectively). Narrowing portions 216a, 218a, 220a can be similar or identical to narrowing portions 116a, 118a, 120a discussed above with reference to edge member 116, edge member 118, and spine member 120 and the number of narrowing portions 216a, 218a, 220a can be similar to those discussed above with reference to edge member 116, edge member 118, and spine member 120.

[0123] FIGS. 4C and 4D illustrate top and side exploded perspective views of strap 200a. FIGS. 4C-4D also illustrate channels 250 detached (for example, disassembled) from base 210a. FIG. 4E illustrates a cross-section taken through strap 200a as shown in FIG. 4A and further illustrates channels 250 secured to base 210a (for example, secured to stems 230). FIG. 4F illustrates an enlarged side view of a channel 250 secured to a stem 230.

[0124] Channel 250 can be sized and/or shaped to secure to and/or surround stem 230 or a portion thereof. In some implementations, channel 250 is configured to surround a portion of stem 230. In some implementations, channel 250 is configured to surround less than an entirety of a cross-section of stem 230. Channel 250 can include a web 250a and one or more legs extending from web 250a. For example, channel 250 can include one or both of legs 250b, 250c that can extend from web 250a. Legs 250b, 250c can extend transverse (for example, perpendicular to) web 250a. Legs 250b, 250c can extend from ends of web 250a, for example, opposing ends of web 250a. In some implementations, legs 250b, 250c are curved, for example, along all or a portion of lengths of legs 250b, 250c. In some implementations, legs 250b, 250c extend from web 250a and are curved toward each other. In some implementations, legs 250b, 250c are curved along an entirety of their lengths. In some implementations, web 250a comprises a greater length than one or both of legs 250b, 250c. Alternatively, in some implementations, web 250a has an equal or smaller length than one or both of legs 250b, 250c. In some implementations, web 250a is substantially planar. In some implementations, web 250a is not curved. In some implementations, channel 250 comprises a C-shape.

[0125] With reference to at least FIG. 4F, stem 230 can include a top portion 230a, a bottom portion 230b opposite the top portion 230a, and sides 230c, 230d. When the strap 200a is in use, for example when a wearable device 1 is secured to a user, bottom portion 230b can face toward skin of the wearer and/or be positioned closer to skin of the wearer than top portion 230a, and top portion 230a can face away from skin of the wearer and/or be positioned farther from skin of the wearer than bottom portion 230b. Top portion 230a and sides 230c, 230d can be configured to accommodate a size and/or shape of web 250a and legs 250b, 250c of channel 250 such that, when channel 250 is secured to stem 230, web 250a is positioned adjacent to and/or contact the top portion 230a and legs 250b, 250c are positioned adjacent to and/or to contact sides 230c, 230d. Bottom portion 230b can be configured to accommodate a size and/or shape of ends of legs 250b, 250c such that, when channel 250 is secured to stem 230, ends of legs 250b, 250c

are positioned adjacent to and/or contact bottom portion 230b. Bottom portion 230b and ends of legs 250b, 250c can cooperate to form a generally smooth transition. For example, an outer surface of ends of legs 250b, 250c can be substantially flush with an outer surface of bottom portion 230b. In some implementations, a distance by which the bottom portion 230b extends (for example, downward) from a remaining portion of the stem 230 a distance that is substantially equal to a thickness of leg 250b and/or leg 250c such that outer surfaces of the bottom portion 230b and the legs 250b, 250c are substantially flush. In some implementations, ends of legs 250b, 250c are separated by a gap G_1 which can be substantially equal to a width of the bottom portion 230b.

[0126] Channel 250 can surround less than an entirety of stem 230 when secured thereto. In some implementations, channel 250 surrounds less than approximately 90%, less than approximately 80%, less than approximately 70%, or less than approximately 60% of a perimeter of a cross-section of stem 230 when secured to stem 230. Additionally or alternatively, in some implementations, channel 250 surrounds at least approximately 10%, at least approximately 20%, at least approximately 30%, at least approximately 40%, at least approximately 50%, at least approximately 60%, at least approximately 70%, or at least approximately 80% of a perimeter of a cross-section of stem 230 when secured to stem 230.

[0127] In some implementations, when channel 250 secures to stem 230, channel 250 and stem 230 can form a generally rounded shape, for example, an oblong shape. In some implementations, channel 250 is formed to include gap G_1 and channel 250 can be flexed (for example temporarily flexed) to allow the channel 250 to be positioned around and/or secured to stem 230. In some implementations, channel 250 can be snapped into engagement around stem 230.

[0128] Strap 200a can be manufactured and/or assembled in a variety of ways. In some implementations, band 210a is formed via a molding (for example, injection molding) process. For example, ends 212, 214, edge members 216, 218, spine member 220, stems 230, tip 226, and/or coupling portion 228 can be formed via injection molding of a material, for example, an elastomeric material. Such elastomeric material can comprise silicone and/or rubber, for example. Such molding process can be utilized to form openings 224, openings 222, and/or opening 229. Channels 250 can be formed of a metallic material (for example, via an extrusion process). As discussed previously, channels 250 can comprise stainless steel. In some implementations, channels 250 only comprise a metallic material. In some implementations, the number of channels 250 corresponds to the number of stems 230 in base 210a. After the channels 250 are formed, channels 250 can be secured to stems 230 of base 210a. In some implementations, channels 250 are configured and/or are secured to stem 230 so as to be removably attachable by a user (for example, a wearer of a wearable device 1 including strap 200a). Alternatively, in some implementations, channels 250 are configured and/or are secured to stem 230 so as to be not removably attachable by a user (for example, a wearer of a wearable device 1 including strap 200a).

[0129] FIGS. 5A-5F illustrate a strap 300a. Strap 300a can be utilized with a wearable device 1 and/or a watch module 10 in a similar or identical manner as that described else-

where herein with reference to strap 100a. Strap 300a can be similar or identical to strap 100a in some or many respects. With reference to at least FIGS. 5A-5B, strap 300a can include a base 310a (which may also be referred to as a “main body”), an end 312, an end 314 opposite end 312, a length extending between ends 312, 314, sides that can include and/or be defined by edge members 316, 318, a tip 326 at or near end 314, and/or a coupling portion 328 including an opening 329 at or near end 312. End 312, end 314, edge members 316, 218, tip 326, coupling portion 328, and/or opening 329 can be similar or identical to end 112, end 114, edge members 116, 118, tip 126, coupling portion 128, and/or opening 129 described above with reference to strap 100a. Base 310a can be similar or identical to base 110a in some or many respects. For example, base 310a can include one or more and/or a plurality of openings 322 that can be similar or identical to openings 122 discussed above with respect to base 110a. As another example, base 310a can include a spine member 320 which can be similar or identical to spine member 120 discussed above. Spine member 320 can include one or more of a plurality of openings 324 that can be similar or identical to openings 324, and the number of openings 324 in spine member 320 can be similar or identical to the number of openings 124 discussed above with respect to spine member 120. With reference to at least FIG. 5C, edge member 316, edge member 318, and spine member 320 can include narrowing portions 316a, 318a, 320a that can be identical to narrowing portions 116a, 118a, 120a discussed above with respect to edge member 116, edge member 118, and spine member 120 (respectively). In some implementations, strap 300a is identical to strap 100a except with respect to the stems 330 and channels 350 which are discussed further below. The number of openings 322, openings 324, and/or stems 330 can be similar or identical to the number of openings 122, openings 124, and/or stems 130 discussed above with respect to base 110a.

[0130] Base 310a can comprise a pliable (for example, stretchable) material. In some implementations, base 310a only comprises one material, and such material can be pliable (for example, stretchable). For example, 310a can comprise an elastomeric material, such as rubber and/or silicone. In some implementations, base 310a does not comprise a metallic material.

[0131] Similar to strap 100a, strap 300a can include one or more or a plurality of stems 330. FIG. 5C-5D illustrate channels 350 detached (for example, disassembled) from base 310a. With reference to at least FIGS. 5G-5H, stem 330 can comprise a rounded cross-section. Stem 330 can comprise an oblong shape. Stem 330 can include a top portion 330a, a bottom portion 330b opposite the top portion 330a, and sides 330c, 330d. When the strap 300a is in use, for example when a wearable device 1 is secured to a user, bottom portion 330b can face toward skin of the wearer and/or be positioned closer to skin of the wearer than top portion 330a, and top portion 330a can face away from skin of the wearer and/or be positioned farther from skin of the wearer than bottom portion 330b.

[0132] Channel 350 can include a web 350a and one or more legs extending from web 350a. For example, channel 350 can include one or both of legs 350b, 350c that can extend from web 350a. Legs 350b, 350c can extend transverse (for example, perpendicular to) web 350a. Legs 350b, 350c can extend from ends of web 350a, for example,

opposing ends of web **350a**. In some implementations, web **350a** comprises a greater length than one or both of legs **350b**, **350c**. Alternatively, in some implementations, web **350a** has an equal or smaller length than one or both of legs **350b**, **350c**. In some implementations, web **350a** is substantially planar.

[10133] Channel **350** can comprise a metallic material, such as stainless steel. In some implementations, channel **350** only comprises a metallic material. In some implementations, channel **350** does not comprise an elastomeric material. For example, in some implementations, channel **350** does not comprise rubber and/or do not comprise silicone. In some implementations, channel **350** does not comprise leather and/or do not comprise fabric.

[10134] Channels **350** can be secured to base **310a** in a variety of ways. Channels **350** can be secured over stems **330** by inserting legs **350b**, **350c** at least partially through openings **322** of base **310a**. FIGS. 5C-5D illustrates channels **350** positioned above the stems **330** (for example, prior to insertion of legs **350b**, **350c** through openings **322**) and FIGS. 5E and 5G illustrate channels **350** and stems **330** after such insertion. In some implementations, after legs **350b**, **350c** are inserted through openings **322**, legs **350b**, **350c** can be bent (for example, crimped) around the stems **330** as illustrated in FIGS. 5F and 5H. In some implementations, channel **350** is secured to stem so as to surround an entirety of a cross-section of stem **330**. In some implementations, channel **350** is secured to stem so as to surround less than an entirety of a cross-section of stem **330**, for example, such that a gap **G2** exists between ends of legs **350b**, **350c** when secured around stem **330**. In some implementations, channel **350** surrounds at least approximately 80%, at least approximately 85%, at least approximately 90%, or at least approximately 95% of a perimeter of a cross-section of stem **330** when secured to stem **330**. Additionally or alternatively, in some implementations, channel **350** surrounds greater than approximately 80% but less than 100% of the cross-section of stem **330**, greater than approximately 90% but less than 100% of the cross-section of stem **330**, or greater than approximately 95% but less than 100% of the cross-section of stem **330**. In some implementations, gap **G₂** is less than approximately 0.5 inch, less than approximately 0.4 inch, less than approximately 0.3 inch, less than approximately 0.2 inch, less than approximately 0.1 inch, less than approximately 0.05 inch, less than approximately 0.01 inch, or less than approximately 0.005 inch, for example.

[10135] FIGS. 6A-6D illustrate a strap **400a**. Strap **400a** can be utilized with a wearable device **1** and/or a watch module **10** in a similar or identical manner as that described elsewhere herein with reference to strap **100a**. Strap **400a** can be similar or identical to strap **100a** in some or many respects. With reference to at least FIGS. 6A-6B, strap **400a** can include a base **410a** (which may also be referred to as a “main body”), an end **412**, an end **414** opposite end **412**, a length extending between ends **412**, **414**, sides that can include and/or be defined by edge members **416**, **418**, a tip **426** at or near end **414**, and/or a coupling portion **428** including an opening **429** at or near end **412**. End **412**, end **414**, edge members **416**, **218**, tip **426**, coupling portion **428**, and/or opening **429** can be similar or identical to end **112**, end **114**, edge members **116**, **118**, tip **126**, coupling portion **128**, and/or opening **129** described above with reference to strap **100a**. Base **410a** can be similar or identical to base **110a** in some or many respects. For example, base **410a** can

include one or more and/or a plurality of openings **422** that can be similar or identical to openings **122** discussed above with respect to base **110a**. As another example, base **410a** can include a spine member **420** which can be similar or identical to spine member **120** discussed above. Spine member **420** can include one or more of a plurality of openings **424** that can be similar or identical to openings **124**, and the number of openings **424** in spine member **420** can be similar or identical to the number of openings **124** discussed above with respect to spine member **120**. Edge member **416**, edge member **418**, and spine member **420** can include narrowing portions **416a**, **418a**, **420a** that can be identical to narrowing portions **116a**, **118a**, **120a** discussed above with respect to edge member **116**, edge member **118**, and spine member **120** (respectively). In some implementations, strap **400a** is identical to strap **100a** except with respect to the stems **430** and channels **450** which are discussed further below. The number of openings **422**, openings **424**, and/or stems **430** can be similar or identical to the number of openings **122**, openings **124**, and/or stems **130** discussed above with respect to base **110a**.

[10136] Base **410a** can comprise a pliable (for example, stretchable) material. In some implementations, base **410a** only comprises one material, and such material can be pliable (for example, stretchable). For example, **410a** can comprise an elastomeric material, such as rubber and/or silicone. In some implementations, base **410a** does not comprise a metallic material.

[10137] Similar to strap **100a**, strap **400a** can include one or more or a plurality of stems **430**. With reference to at least FIG. 6D, stem **430** can comprise a rounded cross-section. For example, stem **430** can comprise a rounded rectangular shape. Channel **450** can comprise a cross-section that corresponds to a cross-section of the stem **430**. In some implementations, channel **450** comprises a rounded rectangular cross-section. Channel **450** can be tubular. Channel **450** can surround an entirety of a cross-section of stem **430**.

[10138] Channel **450** can comprise a metallic material, such as stainless steel. In some implementations, channel **450** only comprises a metallic material. In some implementations, channel **450** does not comprise an elastomeric material. For example, in some implementations, channel **450** does not comprise rubber and/or do not comprise silicone. In some implementations, channel **450** does not comprise leather and/or do not comprise fabric.

[10139] FIGS. 6E-6L illustrate an exemplary method of manufacturing strap **400a**. With reference to FIG. 6E, one or more or a plurality of hollow tubes **480** can be obtained or formed (for example, via a metal extrusion process). In some implementations, tubes **480** are made of a metal or metallic material, for example stainless steel. In some implementations, tubes **480** only comprise a metallic material and do not comprise rubber, silicone, leather, and/or fabric. In some implementations, tubes **480** are formed to have a rounded cross-section, for example, a rounded rectangular cross-section. As illustrated in FIG. 6F, tubes **480** can be cut into shorter sections to form strap members, such as channels **450**. In some implementations, all sharp edges of the tubes **480** are removed via deburring.

[10140] With reference to FIGS. 6G-6H, channels **450** can be arranged in a mold, for example a first mold portion **490**. FIG. 6G illustrates a top perspective view of channels **450** in mold portion **490** and FIG. 6H illustrates a top view of channels **450** in mold portion **490**. A second mold portion

492 can be positioned adjacent mold portion **490** to form an enclosed interior. In some implementations, mold portion **490** and/or **492** includes locations for each channel **450** arranged in multiple columns of multiple rows, and each of such location can be defined by walls or ribs in mold portion **490** and/or **492**. In some implementations, mold portion **490** and/or **492** is configured to provide two columns and a plurality of rows within each column for receiving each of the channels **450**. The number of columns and rows in the mold portion **490** and/or **492** can vary and correspond to the number of columns and rows of stems **430** and/or channels **450** for the strap **400a**. The mold portion **490** and/or **492** can include one or more or a plurality of voids and/or portions configured to define portions of the base **410a** of strap **400a** after a material is inserted into the voids. For example, mold portion **490** and/or **492** can be configured to allow formation of (separately or together) any of the components discussed above with respect to base **410a**.

[0141] After mold portions **490**, **492** are assembled to form an enclosed interior that houses channels **450**, a material can be inserted (for example, injected) into interior space defined by the mold portions **490**, **492**, for example, via an opening or port **492**. The mold portions **490**, **492** and/or channels **450** can be configured to allow such material to fill void spaces within the interior space and inside hollow portions of the channels **450**. Such material can be a pliable material, for example, an elastomeric material including rubber and/or silicone. After the material cures, mold portions **490**, **492** can be separated from each other and the finished strap **400a** can be removed. Such finished strap **400a** can include any of the features and/or components discussed above with respect to strap **400a**.

[0142] Any of the straps described herein can be formed, at least in part, via a molding process with mold portions that can be similar or identical to mold portions **490**, **492** in some or many respects. For example, any of the bases of the straps described herein can be formed via a molding process with mold portions that can be similar or identical to mold portions **490**, **492** in some or many respects.

Additional Considerations and Terminology

[0143] Although this invention has been disclosed in the context of certain preferred embodiments, it should be understood that certain advantages, features and aspects of the systems, devices, and methods may be realized in a variety of other embodiments. Additionally, it is contemplated that various aspects and features described herein can be practiced separately, combined together, or substituted for one another, and that a variety of combination and subcombinations of the features and aspects can be made and still fall within the scope of the invention. Furthermore, the systems and devices described above need not include all of the modules and functions described in the preferred embodiments.

[0144] Conditional language used herein, such as, among others, “can,” “could,” “might,” “may,” “e.g.,” and the like, unless specifically stated otherwise, or otherwise understood within the context as used, is generally intended to convey that certain features, elements, and/or steps are optional. Thus, such conditional language is not generally intended to imply that features, elements, and/or steps are in any way required or that one or more embodiments necessarily include logic for deciding, with or without other input or prompting, whether these features, elements, and/or steps

are included or are to be always performed. The terms “comprising,” “including,” “having,” and the like are synonymous and are used inclusively, in an open-ended fashion, and do not exclude additional elements, features, acts, operations, and so forth. Also, the term “or” is used in its inclusive sense (and not in its exclusive sense) so that when used, for example, to connect a list of elements, the term “or” means one, some, or all of the elements in the list. Further, the term “each,” as used herein, in addition to having its ordinary meaning, can mean any subset of a set of elements to which the term “each” is applied.

[0145] Conjunctive language such as the phrase “at least one of X, Y, and Z,” unless specifically stated otherwise, is otherwise understood with the context as used in general to convey that an item, term, etc. may be either X, Y, or Z. Thus, such conjunctive language is not generally intended to imply that certain embodiments require the presence of at least one of X, at least one of Y, and at least one of Z.

[0146] Language of degree used herein, such as the terms “approximately,” “about,” “generally,” and “substantially” as used herein represent a value, amount, or characteristic close to the stated value, amount, or characteristic that still performs a desired function or achieves a desired result. For example, the terms “approximately,” “about,” “generally,” and “substantially” may refer to an amount that is within less than 10% of, within less than 5% of, within less than 1% of, within less than 0.1% of, and within less than 0.01% of the stated amount. As another example, in certain embodiments, the terms “generally parallel” and “substantially parallel” refer to a value, amount, or characteristic that departs from exactly parallel by less than or equal to 10 degrees, 5 degrees, 3 degrees, or 1 degree. As another example, in certain embodiments, the terms “generally perpendicular” and “substantially perpendicular” refer to a value, amount, or characteristic that departs from exactly perpendicular by less than or equal to 10 degrees, 5 degrees, 3 degrees, or 1 degree.

[0147] Although certain embodiments and examples have been described herein, it will be understood by those skilled in the art that many aspects of the systems and devices shown and described in the present disclosure may be differently combined and/or modified to form still further embodiments or acceptable examples. All such modifications and variations are intended to be included herein within the scope of this disclosure. A wide variety of designs and approaches are possible. No feature, structure, or step disclosed herein is essential or indispensable.

[0148] Any methods disclosed herein need not be performed in the order recited. The methods disclosed herein may include certain actions taken by a practitioner; however, they can also include any third-party instruction of those actions, either expressly or by implication.

[0149] The methods and tasks described herein may be performed and fully automated by a computer system. The computer system may, in some cases, include multiple distinct computers or computing devices (e.g., physical servers, workstations, storage arrays, cloud computing resources, etc.) that communicate and interoperate over a network to perform the described functions. Each such computing device typically includes a processor (or multiple processors) that executes program instructions or modules stored in a memory or other non-transitory computer-readable storage medium or device (e.g., solid state storage devices, disk drives, etc.). The various functions disclosed

herein may be embodied in such program instructions, and/or may be implemented in application-specific circuitry (e.g., ASICs or FPGAs) of the computer system. Where the computer system includes multiple computing devices, these devices may, but need not, be co-located. The results of the disclosed methods and tasks may be persistently stored by transforming physical storage devices, such as solid state memory chips and/or magnetic disks, into a different state. The computer system may be a cloud-based computing system whose processing resources are shared by multiple distinct business entities or other users.

[0150] Depending on the embodiment, certain acts, events, or functions of any of the processes or algorithms described herein can be performed in a different sequence, can be added, merged, or left out altogether (for example, not all described operations or events are necessary for the practice of the algorithm). Moreover, in certain embodiments, operations or events can be performed concurrently, e.g., through multi-threaded processing, interrupt processing, or multiple processors or processor cores or on other parallel architectures, rather than sequentially.

[0151] Various illustrative logical blocks, modules, routines, and algorithm steps that may be described in connection with the disclosure herein can be implemented as electronic hardware (e.g., ASICs or FPGA devices), computer software that runs on general purpose computer hardware, or combinations of both. Various illustrative components, blocks, and steps may be described herein generally in terms of their functionality. Whether such functionality is implemented as specialized hardware versus software running on general-purpose hardware depends upon the particular application and design constraints imposed on the overall system. The described functionality can be implemented in varying ways for each particular application, but such implementation decisions should not be interpreted as causing a departure from the scope of the disclosure.

[0152] Moreover, various illustrative logical blocks and modules that may be described in connection with the disclosure herein can be implemented or performed by a machine, such as a general purpose processor, a digital signal processor (DSP), an application specific integrated circuit (ASIC), a field programmable gate array (FPGA) or other programmable logic device, discrete gate or transistor logic, discrete hardware components, or any combination thereof designed to perform the functions described herein. A general purpose processor can be a microprocessor, but in the alternative, the processor can be a controller, microcontroller, or state machine, combinations of the same, or the like. A processor can include electrical circuitry configured to process computer-executable instructions. A processor can include an FPGA or other programmable device that performs logic operations without processing computer-executable instructions. A processor can also be implemented as a combination of computing devices, e.g., a combination of a DSP and a microprocessor, a plurality of microprocessors, one or more microprocessors in conjunction with a DSP core, or any other such configuration. Although described herein primarily with respect to digital technology, a processor may also include primarily analog components. For example, some or all of the rendering techniques described herein may be implemented in analog circuitry or mixed analog and digital circuitry. A computing environment can include any type of computer system, including, but not limited to, a computer system based on a

microprocessor, a mainframe computer, a digital signal processor, a portable computing device, a device controller, or a computational engine within an appliance, to name a few.

[0153] The elements of any method, process, routine, or algorithm described in connection with the disclosure herein can be embodied directly in hardware, in a software module executed by a processor, or in a combination of the two. A software module can reside in RAM memory, flash memory, ROM memory, EPROM memory, EEPROM memory, registers, hard disk, a removable disk, a CD-ROM, or any other form of a non-transitory computer-readable storage medium. An exemplary storage medium can be coupled to the processor such that the processor can read information from, and write information to, the storage medium. In the alternative, the storage medium can be integral to the processor. The processor and the storage medium can reside in an ASIC. The ASIC can reside in a user terminal. In the alternative, the processor and the storage medium can reside as discrete components in a user terminal.

[0154] While the above detailed description has shown, described, and pointed out novel features, it can be understood that various omissions, substitutions, and changes in the form and details of the devices or algorithms illustrated can be made without departing from the spirit of the disclosure. As can be recognized, certain portions of the description herein can be embodied within a form that does not provide all of the features and benefits set forth herein, as some features can be used or practiced separately from others. The scope of certain embodiments disclosed herein is indicated by the appended claims rather than by the foregoing description. All changes which come within the meaning and range of equivalency of the claims are to be embraced within their scope.

1-83. (canceled)

84. A strap for a wearable device configured to secure to a wrist of a user, the wearable device configured to measure one or more physiological parameters of the user, the strap comprising:

- a base comprising an integral structure made of a first material, the base further comprising:
 - a first end configured to connect to a portion of the wearable device;
 - a second end opposite the first end;
 - a length extending between the first and second ends, wherein the base is configured to bend along the length to allow the strap to wrap around at least a portion of the user's wrist when in use;
 - a width extending between opposite sides of the base;
 - a plurality of openings spaced from one another along the length; and
 - a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width; and
- a plurality of pairs of channels positioned around the plurality of stems, each of the plurality of pairs of channels comprising:
 - a first channel positioned partially around one of the plurality of stems such that the first channel surrounds less than an entirety of the one of the plurality of stems, wherein the first channel comprises a second material; and

a second channel positioned partially around the one of the plurality of stems such that the second channel surrounds less than said entirety of the one of the plurality of stems, wherein the second channel comprises the second material;

wherein the first and second channels are secured to one another around the one of the plurality of stems such that portions of the first and second channels overlap one another;

wherein the second material of the first and second channels is less pliable than the first material of the base.

85. The strap of claim **84**, wherein the first material comprises stainless steel.

86. The strap of claim **84**, wherein the second material comprises at least one of silicone and rubber.

87. The strap of claim **84**, wherein:

the first channel comprises a web and legs extending from opposite ends of the web of the first channel;

the second channel comprises a web and legs extending from opposite ends of the web of the second channel; and

the legs of the first channel overlap the legs of the second channel.

88. The strap of claim **87**, wherein the webs of the first and second channels do not overlap one another.

89. The strap of claim **87**, wherein the webs of the first and second channels are generally planar and wherein the legs of the first and second channels are curved.

90. The strap of claim **87**, wherein the legs of the first channel overlap only the legs of the second channel.

91. The strap of claim **87**, wherein:

the one of the plurality of stems comprises a top portion, a bottom portion opposite the top portion, and opposing sides connecting the top and bottom portions;

the sides of the one of the plurality of stems are positioned adjacent the legs of the second channel; and

the overlapping legs of the first and second channels, non-overlapping portions of the first and second channels, and the sides of the one of the plurality of stems cooperate to define a generally rounded shape around the one of the plurality of stems.

92. The strap of claim **91**, wherein:

the legs of the second channel contact the sides of the one of the plurality of stems; and

the sides of the one of the plurality of stems are configured such that at least a portion of an outer surface of each of the legs of the second channel is substantially flush with a plane of the top portion of the one of the plurality of stems.

93. The strap of claim **84**, wherein:

the base further comprises:

a first edge member at least partially defining a first side of the base between the first and second ends;

a second edge member at least partially defining a second side of the base between the first and second ends, said second side being opposite said first side; and

a spine member extending along at least a portion of the length and positioned between the first and second edge members, wherein the spine member is generally parallel to the first and second edge members; and

the plurality of openings comprises:

a first plurality of openings spaced from one another along at least a portion of the length and extending between the first edge member and the spine member; and

a second plurality of openings spaced from one another along at least a portion of the length and extending between the second edge member and the spine member; and

the plurality of stems comprises:

a first plurality of stems, each of the first plurality of stems positioned between two of said first plurality of openings and extending between the first edge member and the spine member; and

a second plurality of stems, each of the second plurality of stems positioned between two of said second plurality of openings and extending between the second edge member and the spine member.

94. A wearable device comprising the strap of claim **84**, wherein the wearable device is configured to measure at least one of oxygen saturation and pulse rate of the user.

95. A strap for a wearable device configured to secure to a wrist of a user, the strap comprising:

a base comprising an integral structure made of a first material, the base further comprising:

a first end configured to connect to a portion of the wearable device;

a second end opposite the first end;

a length extending between the first and second ends;

a width extending between opposite sides of the base;

a plurality of openings spaced from one another along the length; and

a plurality of stems, each of the plurality of stems positioned between two of said plurality of openings and extending generally in a direction of the width; and

a plurality of pairs of channels positioned around the plurality of stems, each of the plurality of pairs of channels comprising:

a first channel positioned at least partially around one of the plurality of stems; and

a second channel positioned at least partially around the one of the plurality of stems and secured to the first channel;

wherein the first and second channels comprise a second material that is less pliable than the first material of the base.

96. The strap of claim **95**, wherein the first material comprises a metallic material and wherein the second material comprises at least one of silicone and rubber.

97. The strap of claim **95**, wherein the first and second channels are not integral with one another.

98. The strap of claim **95**, wherein:

the first channel comprises a web and legs extending from opposite ends of the web of the first channel;

the second channel comprises a web and legs extending from opposite ends of the web of the second channel; and

the legs of the first channel overlap the legs of the second channel.

99. The strap of claim **98**, wherein the webs of the first and second channels do not overlap one another.

100. The strap of claim **98**, wherein:

the one of the plurality of stems comprises a top portion,
a bottom portion opposite the top portion, and opposing
sides connecting the top and bottom portions;

the sides of the one of the plurality of stems contact the
legs of the second channel;

the legs of the second channel are sandwiched between
the sides of the one of the plurality of stems and the legs
of the first channel; and

the overlapping legs of the first and second channels,
non-overlapping portions of the first and second chan-
nels, and the sides of the one of the plurality of stems
cooperate to define a generally rounded shape around
the one of the plurality of stems.

101. A strap for a wearable device configured to secure to
a portion of a user's body, the strap comprising:

a base comprising a first material, the base further com-
prising:

a first end, a second end opposite the first end, and a
length extending between the first and second ends;

a plurality of openings spaced from one another along
the length; and

a plurality of stems, each of the plurality of stems
positioned between two of said plurality of openings;
and

a plurality of strap members positioned around the plu-
rality of stems and comprising a second material that is
less pliable than the first material.

102. The strap of claim **101**, wherein the first material
comprises a metallic material and wherein the second mate-
rial comprises at least one of silicone and rubber.

103. The strap of claim **101**, wherein the plurality of strap
members comprises a plurality of pairs of channels posi-
tioned around the plurality of stems, each of the plurality of
pairs of channels comprising:

a first channel positioned partially around one of the
plurality of stems such that the first channel surrounds
less than an entirety of the one of the plurality of stems;
and

a second channel positioned partially around the one of
the plurality of stems such that the second channel
surrounds less than said entirety of the one of the
plurality of stems;

wherein the first and second channels are secured to one
another around the one of the plurality of stems such
that portions of the first and second channels overlap
one another.

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